

Date: Monday, 02/06/2008 4:33:18 PM
User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACEPOD ASSEMBLY RH/ DSI 9335
Job Number	: 39642	Part Number	: D350600242
Estimate Number	: 12779	Drawing Number	: IIN REV.C PG11,18-21
P.O. Number	:	Project Number	: N/A
This Issue	: 02/06/2008 S.O. No. :	Drawing Revision	: C
Prsht Rev.	: NC	Material	:
First Issue	: / / Type : SMALL /MED FAB	Due Date	: 25/06/2008 Qty: 1 Um: Each
Previous Run	: 39188		
Written By	:		
Checked & Approved By	: <u>JLD 08.6.02</u>		
Comment	: Est Rev:A 07.03.07 new issue EC est rev B 07.04.16 reformat, D3188 rev.E EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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JLD 08.6.09



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-600-242 CHG001

S 08/08/02

2.0	39642A	SPACEPOD BODY RH
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Comment: Sub-Component SPACEPOD BODY RH
D3188-2M Batch: 339642A

080814

3.0	39642B	SPACEPOD DOOR RH
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Comment: Sub-Component SPACEPOD DOOR RH
D3186-4 Batch: 339642B

080814

4.0	D31872	Spacepod Floor
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3187-2	Floor	<u>3396</u> 31836

31836

080814

5.0	ALS41032130	Insert
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Comment: Qty.: 28.0000 Each(s)/Unit Total : 28.0000 Each(s)

insert

batch: M105819

080814

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 39642

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

A3235020935

Washer - Countersunk



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Washer - Countersunk

MS 6150

[Signature]

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1-Drill holes in D3188-2 using drill jig DT8971
2-Open holes in D3188-2 body floor to Ø0.297" as per dwg D3188
3-Deburr
4-Install inserts in D3188-2 as per Dwg D3188.

080814

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-06-14

9.0

D2986

Black Neoprene Foam .125



Comment: Qty.: 5.9010 sf(s)/Unit Total : 5.9010 sf(s)
neoprene foam
batch: *130632*

080814

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut D2986 Neoprene Foam per template D2986T1

080814

11.0

D30153

Locknut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Lock Nut
batch: *39563*

[Signature]

12.0

D35547

Ball Stud



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
BALL STUD *37 674*

8/7/31 (1)

W/O:		WORK ORDER CHANGES					
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Job Number: 39642

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

AN960JD516

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Washer

BATCH: M107959

Lu

14.0

D35672

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

DECAL

batch: 38678

Lu

15.0

D2237

Striker Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Batch: 38807

Lu

16.0

MS20426AD45

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Batch: 3409

Lu

17.0

D35381

Hinge Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

HINGE BRACKET

batch: 35404

Lu

18.0

D2179

Doublier



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Batch: 30630

Lu

19.0

AN526C832R24

screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

batch: M104603

Lu 8/1/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number: 39642

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

AN960JD8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch:

M107650

u

21.0

MS21042L08

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

batch:

M107990

u

22.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

****This step separates hardware, previous steps is for body & floor****

A 080814

23.0

MS270390811

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch:

M107427

u

24.0

AN960JD8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch:

M107650

u

25.0

NAS1515H3

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch:

M107101

u

26.0

MS21042L08

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch:

M107990

u 8/7/31 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

D2464

3/4 Seal



Comment: Qty.: 11.3400 f(s)/Unit Total : 11.3400 f(s)

3/4 Seal

Cut 127.00" long batch: B35 433

AO 0808 14

28.0

D35672

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

DECAL

batch: 396 78

CU

29.0

D2586

Door Latch



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Door Latch

batch: 38174

CU

30.0

D2585

Mounting Channel



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Latch Clamp

batch: 38813

CU

31.0

D2621

Latch Plate, 350 Spacepod



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Latch Plate

batch: 3 3894

CU

32.0

MS27039115

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: M106903

CU

33.0

AN960JD10

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch: M108558

CU 8/2/3, (1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number: 39642

Part Number: D350600242

Job Number:



Seq. #:	Machine Or Operation:	Description :
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34.0	MS21042L3	Nut
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Nut
batch: M107665

h

35.0	D28571	Hinge Bracket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Hinge Bracket
batch: 38680

h

36.0	D28572	Hinge Bracket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Hinge Bracket
batch: 38680 39786

h

37.0	D2228	Bracket Plate
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Backing Plate
batch: 30678

h

38.0	AN526C832R10	Screw
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Screw
batch: BH104603

h

39.0	AN960JD8	Washer
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Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)
Washer
batch: M107650

h

40.0	MS21042L08	Nut
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Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)
Nut
batch: M107990

h

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number: 39642

Part Number: D350600242

Job Number:



Seq. #:	Machine Or Operation:	Description :
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41.0	D35571	Bracket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BRACKET

batch: 32647

42.0	AN526C832R14	Screw
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Comment: Qty.: 2.0000 Each(s)/Unit Total : * 2.0000 Each(s)

Screw

batch: 9216

43.0	AN526C832R10	Screw
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: 104603

44.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3186-4 door with D3188-2 body as per Dwg ICA-D350-600

Hardware on previous steps is for door ass'y*

1-Drill and plug section I-I and J-J of dwg D3188 p.11 using Hysol 934NA with milled fibres 10% to weight.

A/R Hysol batch: M107908 expire date: 090320

A/R Milled fibres batch: M100859

080814

2-Attach Neoprene Foam to floor using Contact Cement

A/R Contact Cement Batch: M105623

080814

45.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

08-08-18

checked id'd the floor

46.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Wing Walk Spacepod top surface of Pod as per Dwg D3188 & QSI 005 4.4

Batch: M107892

0808-19

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-600-242 PAR #: N/A Fault Category: Prod / Ins. Ass. made small NCR: Yes No DQA: D Date: 08/08/18
 QA: N/C Closed: D Date: 08/08/18

NCR: <u>39642</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-08-18	44	Door did not sit well in the body. Body i door were drilled as per dwg. Door would pull down and go crooked when the bolts were tightened.	<i>[Signature]</i>	Filled holes with Hysol 934NA 107908 milled fibres H100859 Redrilled To achieve better fit of Hinge and door. As per Q51032	<i>[Signature]</i> 080818	<i>[Signature]</i> 08-08-18	<i>[Signature]</i>	<i>[Signature]</i>
08-08-18	44.0	R.C. 2° of holes in the body were off hole in the striker plate was too large. R.C. blow out from W. Jet.	<i>[Signature]</i>	Replace STRIKER plate P2237, one hole too large for rivet B38807	<i>[Signature]</i> 080818	<i>[Signature]</i> 08/08/18	<i>[Signature]</i>	<i>[Signature]</i>

NOTE: Date & initial all entries

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Job Number: 39642

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

47.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Wing Walk

M-A 08/08/19 (14)

48.0

K10021

Spacepod Hardware Kit (-241)



Comment: Qty.: 1.0000 (s)/Unit Total : 1.0000 (s)

B36303

8/8/19

SP

49.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

S 08/08/19

50.0

D350600449

Switch Relocation



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

B36037

SWITCH RELOCATION KIT

SP

51.0

D2985

Label



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Label

batch:

B32470

SP

52.0

D35471

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BRACKET

batch:

B33458

SP

53.0

D35501

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

STRUT

batch:

B36226

SP

54.0

D35527

Gas Spring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CARBON STEEL GAS SPRING

batch:

B32644

8/8/19

SP

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #:

Machine Or Operation:

Description :

55.0

D35547

Ball Stud



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BALL STUD

batch: ~~B37674~~ B37674

34

56.0

AN960JD516

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch: M108246

50

57.0

D30153

Locknut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lock Nut

batch: B37840

8/8/19

50

58.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

5 08/08/22

59.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-600-141

Location: 20

PPP Rev: 10

8/8/22

50

60.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/25

Job Completion



MF 08-08-22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

-241	-242	-243	-245	-246	-247	-248	-249	-449	Part Number	Description
X									D350-600-241	SPACEPOD™ LH, AS350
	X								D350-600-242	SPACEPOD™ RH, AS350/355
		X							D355-600-243	SPACEPOD™ LH, AS355
1		1	X						D350-600-245	DOOR ASSEMBLY LH
	1			X					D350-600-246	DOOR ASSEMBLY RH
					X				D350-600-247	SPACEPOD™ UPGRADE KIT LH
						X			D350-600-248	SPACEPOD™ UPGRADE KIT RH
							X		D350-600-249	SPACEPOD™ UPGRADE KIT
1	1	1						X	D350-600-449	SWITCH RELOCATION KIT
2	2	2							D2174-041	WEB ASSEMBLY
							1		D2464-0360	NEOPRENE SEAL
			1	1					D2589	KEYS, KEY CHAIN
1	1	1							D2985	DECAL
1	1	1			1	1	1		D3015-3	LOCK NUT
			1		1				D3186-3	SPACEPOD DOOR, LH
				1		1			D3186-4	SPACEPOD DOOR, RH
1**		1**							D3187-1	FLOOR
	1**								D3187-2	FLOOR
1									D3188-5	SPACEPOD BODY
	1								D3188-6	SPACEPOD BODY
		1							D3188-7	SPACEPOD BODY
1	1	1			1	1	1		D3547-1	BRACKET
1	1	1			1	1	1		D3550-1	STRUT
			1	1	1	1	1		D3552-7	GAS SPRING
1	1	1			1	1	1		D3554-7	BALL STUD
8	8	8							AN3-3A	BOLT
2	2	2							AN3-10A	BOLT
8	8	8							AN3H4	BOLT
1	1	1			1	1	1		AN5-5A	BOLT
36	36	36							AN525-10R7	SCREW
8	8	8			4	4	4		AN526C832R14	SCREW
7	7	7							MS24694S67	SCREW
1	1	1			1	1	1		MS24694S69	SCREW
			2	2	2	2	2		MS27039-0811	SCREW
8	8	8			1	1	1		AN3235-020-935	WASHER
8	8	8							AN960JD10	WASHER
16	16	16			1	1	1		AN960JD10L	WASHER
			4	4	8	8	8		AN960JD8	WASHER
3	3	3			3	3	3		AN960JD516	WASHER
			2	2	2	2	2		NAS1515H3	NYLON WASHER
			2	2	6	6	6		MS21042L08	NUT
16	16	16			1	1	1		MS21042L3	NUT (or MS21042-3)
1	1	1			1	1	1		MS21042L5	NUT
16	16	16							AKS7-1032-130	INSERT
28**	28**	28**							AKS7-1032-130	INSERT

* PRE-INSTALLED ON D3186-3/-4 SPACEPOD DOOR

** PRE-INSTALLED ON D3188-5/-6/-7 SPACEPOD

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 59642

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Revision: C
Date: 07.02.20

-241	-242	-243	-245	-246	-247	-248	-249	-449	Part Number	Description
								3	M81824/1-2	SPLICE
								2	D3597-1	FEMALE SPADE CONNECTOR
								1	D3598-2-096	EXPANDABLE SLEEVE
								24	D3599-1	TIE-WRAP
								24	D3600-1	TIE-WRAP MOUNT
								24 FT	M22759/16-22-9	WIRE
			1*	1*	1*	1*			D2464-1250	NEOPRENE SEAL
1**		1**	1*		1*				D3567-1	DECAL
	1**			1*		1*			D3567-2	DECAL
			2*	2*					D2586	LATCH
			2*	2*					D2585	MOUNTING CHANNEL
			2*	2*					D2621	LATCH PLATE
			2*	2*					MS27039-1-15	SCREW
					2	2	1		MS27039-1-25	SCREW
			2*	2*	2	2	1		AN960JD10	WASHER
			2*	2*	2	2	1		MS21042L3	NUT (or MS21042-3)
			1*	1*					D2857-1	HINGE BRACKET
			1*	1*					D2857-2	HINGE BRACKET
			2*	2*					D2228	BACKING PLATE
			8*	8*	8	8	8		AN526C832R10	SCREW
			8*	8*	8	8	8		AN960JD8	WASHER
			8*	8*	8	8	8		MS21042L08	NUT
			1*	1*	1*	1*	1		D3557-1	BRACKET
			2*	2*	2*	2*	2		D2228	BACKING PLATE
			1*	1*	1*	1*	1		D3554-7	BALL STUD
			1*	1*	1*	1*	1		AN960JD516	WASHER
			1*	1*	1*	1*	1		D3015-3	LOCK NUT
			2*	2*	2*	2*	2		AN526C832R14	SCREW
			2*	2*	2*	2*	2		AN526C832R10	SCREW
			4*	4*	4*	4*	4		AN960JD8	WASHER
			4*	4*	4*	4*	4		MS21042L08	NUT
2**	2**	2**			1	1	1		D2237	STRIKER PLATE
4**	4**	4**			2	2	2		MS20426AD4-5	RIVET
2**	2**	2**			2	2	2		D3538-1	HINGE BRACKET
2**	2**	2**							D2179	HINGE BRACKET PLATE
4**	4**	4**			4	4	4		AN526C832R24	SCREW
4**	4**	4**			4	4	4		AN960JD8	WASHER
4**	4**	4**			4	4	4		MS21042L08	NUT

* PRE-INSTALLED ON D3186-3/-4 SPACEPOD DOOR

** PRE-INSTALLED ON D3188-5/-6/-7 SPACEPOD

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WORK ORDER
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Revision: C

Date: 07.02.20



RELEASED
07.04.02

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
JB	CB	DRAWING NO.	REV. E	
CHECKED LE	APPROVED [Signature]	D3188	SHEET 1 OF 11	
DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS	
A	03.04.03	NEW ISSUE		
B	06.10.06	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7		
C	06.12.13	REMOVED D0600-XXX LABELS		
D	07.02.22	UPDATE DIMENSIONS		
E	07.04.02	ADD. HYSOL/FIBER OPTION ON SHEET 11		

GENERAL NOTES:

- 1) REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
- 2) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
- 3) MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL
OR DIVINYCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

- 4) MOLD SCHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

- 5) APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
- 6) FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S
- 7) ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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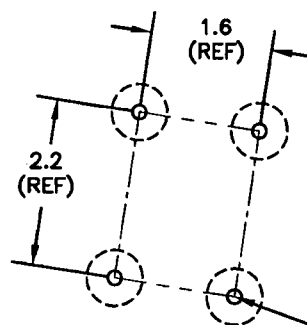
DART

DESIGN	JB	DRAWN BY	CB	DART AEROSPACE LTD
CHECKED	CE	APPROVED	CB	HAWKESBURY, ONTARIO, CANADA
DATE	07.04.02	DRAWING NO.	D3188	REV. E
TITLE	SPACEPOD BODY	SHEET	2 OF 11	SCALE
				NTS

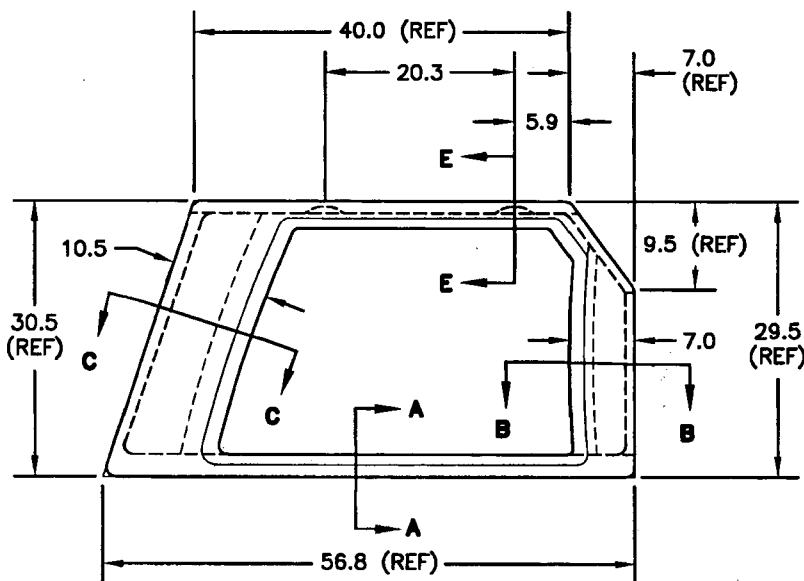
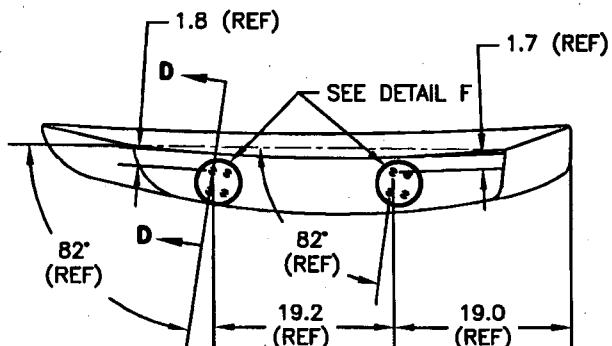
RELEASED

07.04.02

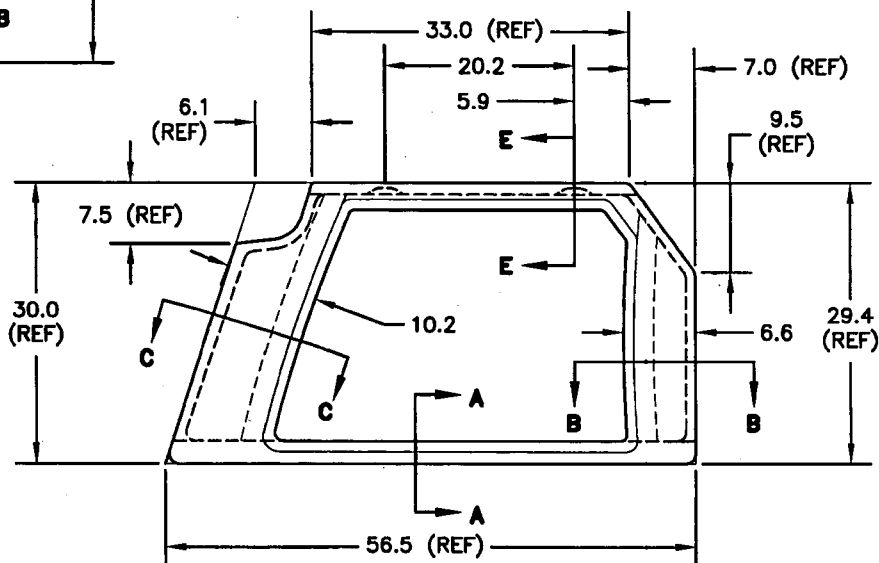
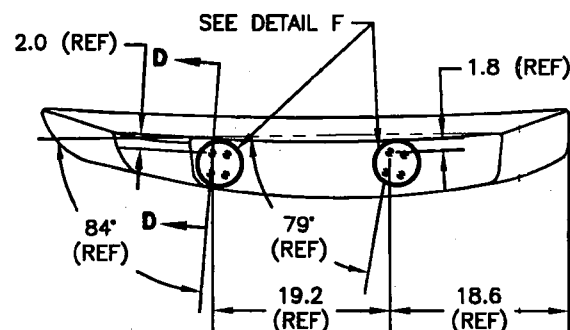
INSTALL
D2213 SPACER
(8 PLACES)
(SEE SECTION D-D)



DETAIL F



D3186-1M SPACEPOD BODY



D3188-3M SPACEPOD BODY

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D3186-1M/3M NOTES:

- 1) REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
- 2) SEE SHEET #4 FOR SECTION VIEWS.

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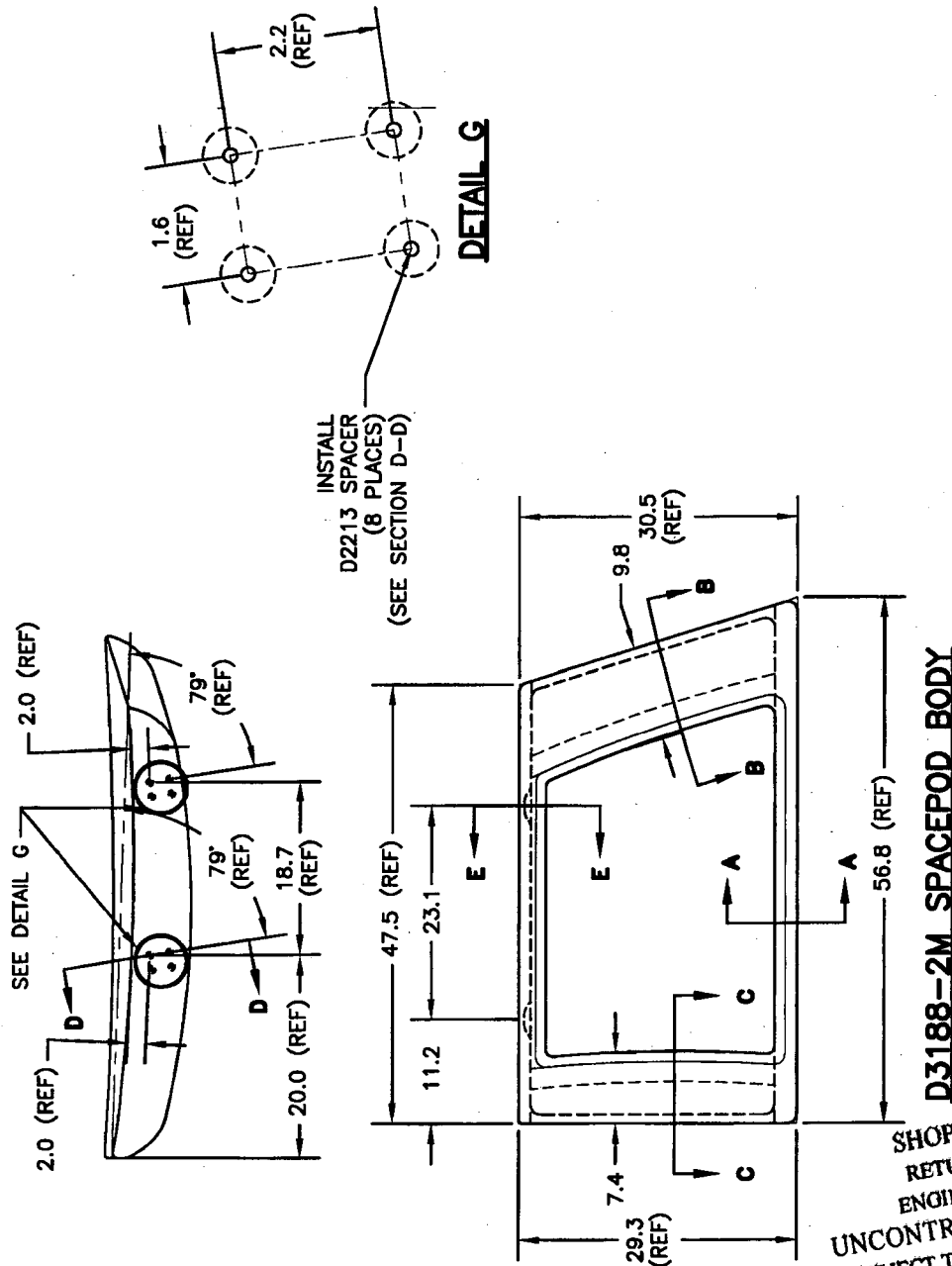
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DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS

RELEASED

07.04.01 [Signature]



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D3186-2M NOTES:
1) REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.
2) SEE SHEET #4 FOR SECTION VIEWS.

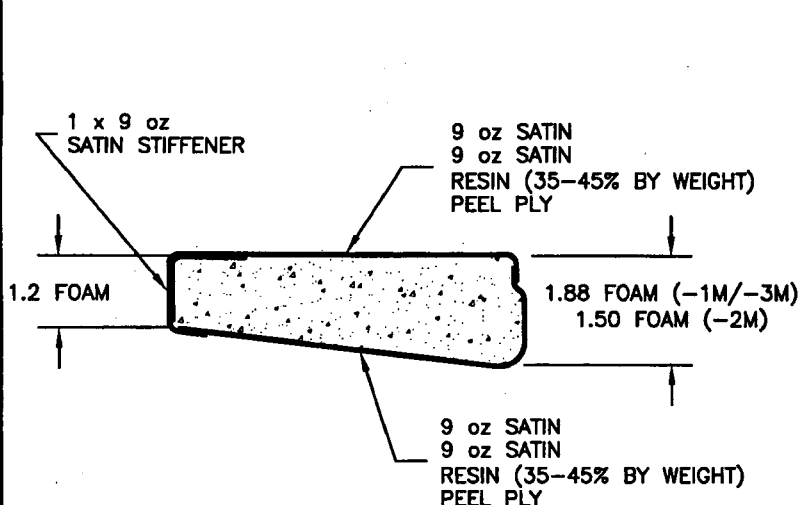
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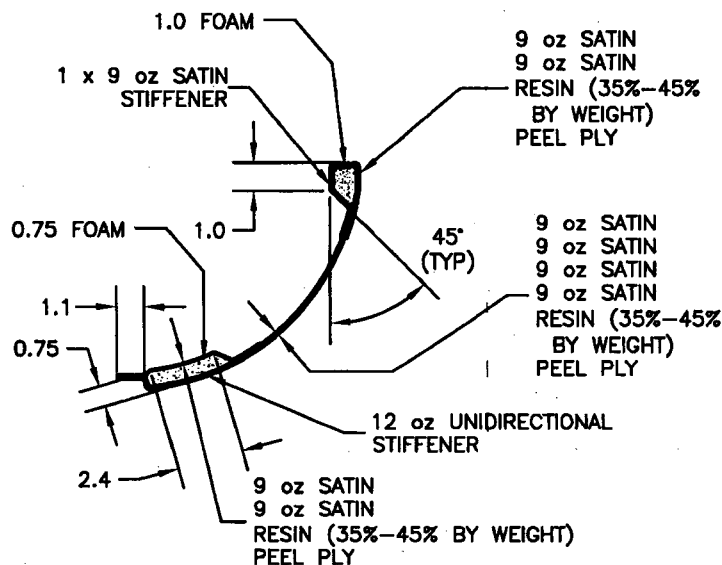


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DATE	07.04.02	DRAWING NO.	D3188	REV. E
TITLE	SPACEPOD BODY	SHEET	4 OF 11	SCALE
				NTS

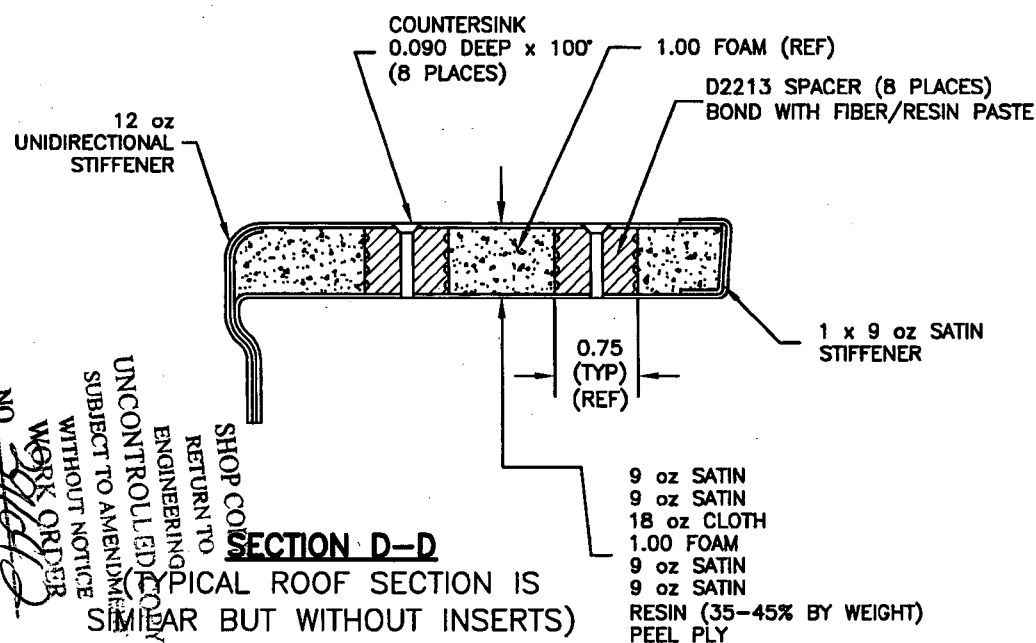
RELEASED
07.04.01



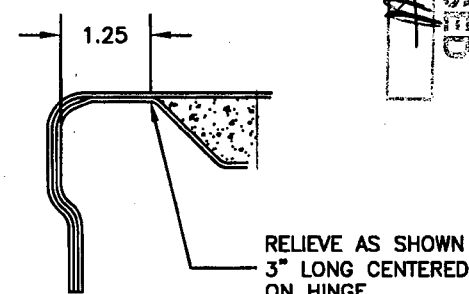
SECTION A-A
(TYPICAL FLOOR SECTION)



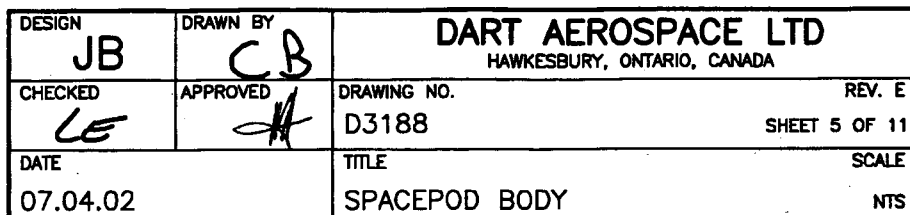
SECTION B-B
(SECTION C-C OPPOSITE)



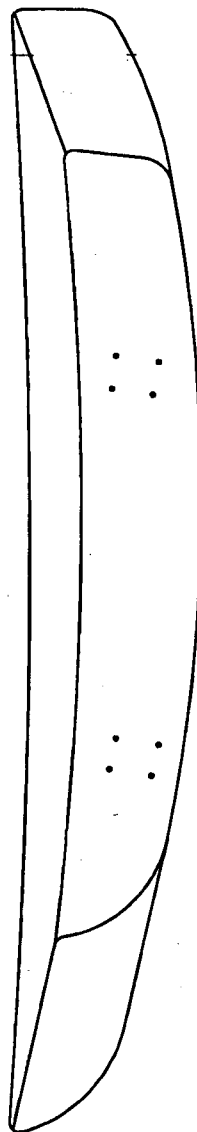
SECTION D-D
(TYPICAL ROOF SECTION IS
SIMILAR BUT WITHOUT INSERTS)



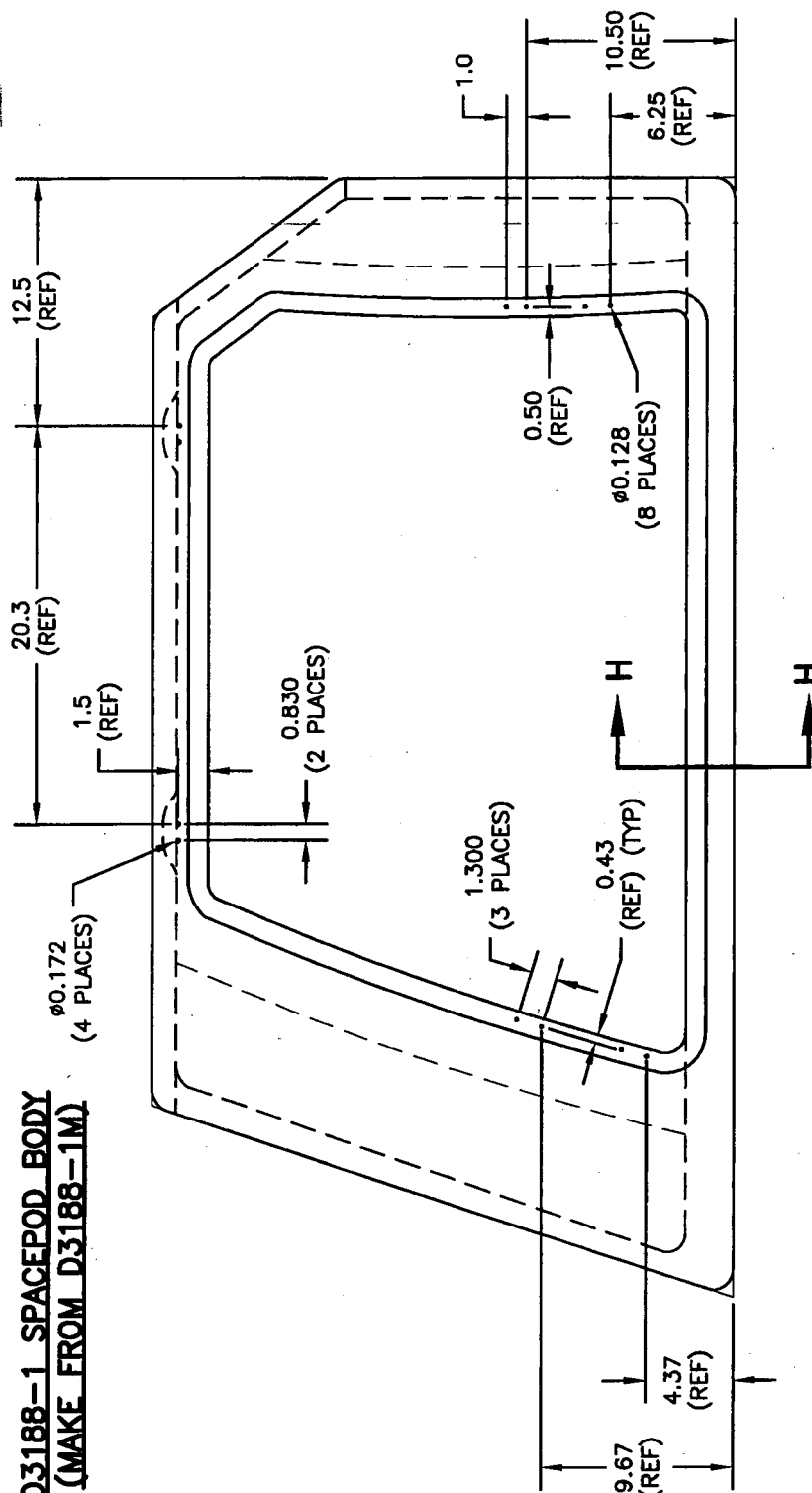
SECTION E-E
(2 PLACES PER POD)



07.04.01



D3188-1 SPACEPOD BODY
(MAKE FROM D3188-1M)



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #111 FOR SECTION VIEW

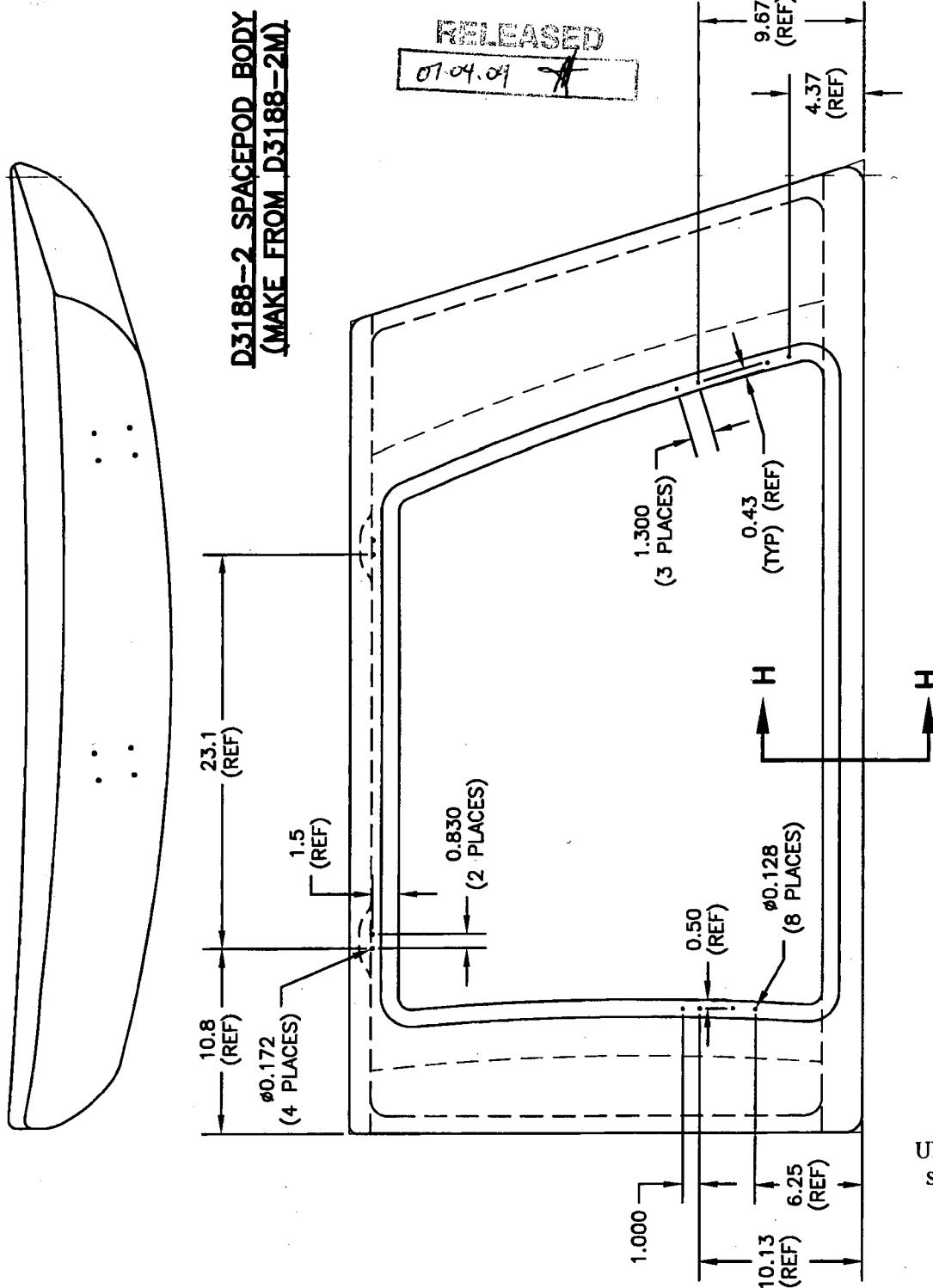
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DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS



NOTES:
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE
TRANSFER DRILLED FROM D3186-2 DOOR DURING ASSEMBLY
SEE SHEET #11 FOR SECTION VIEW

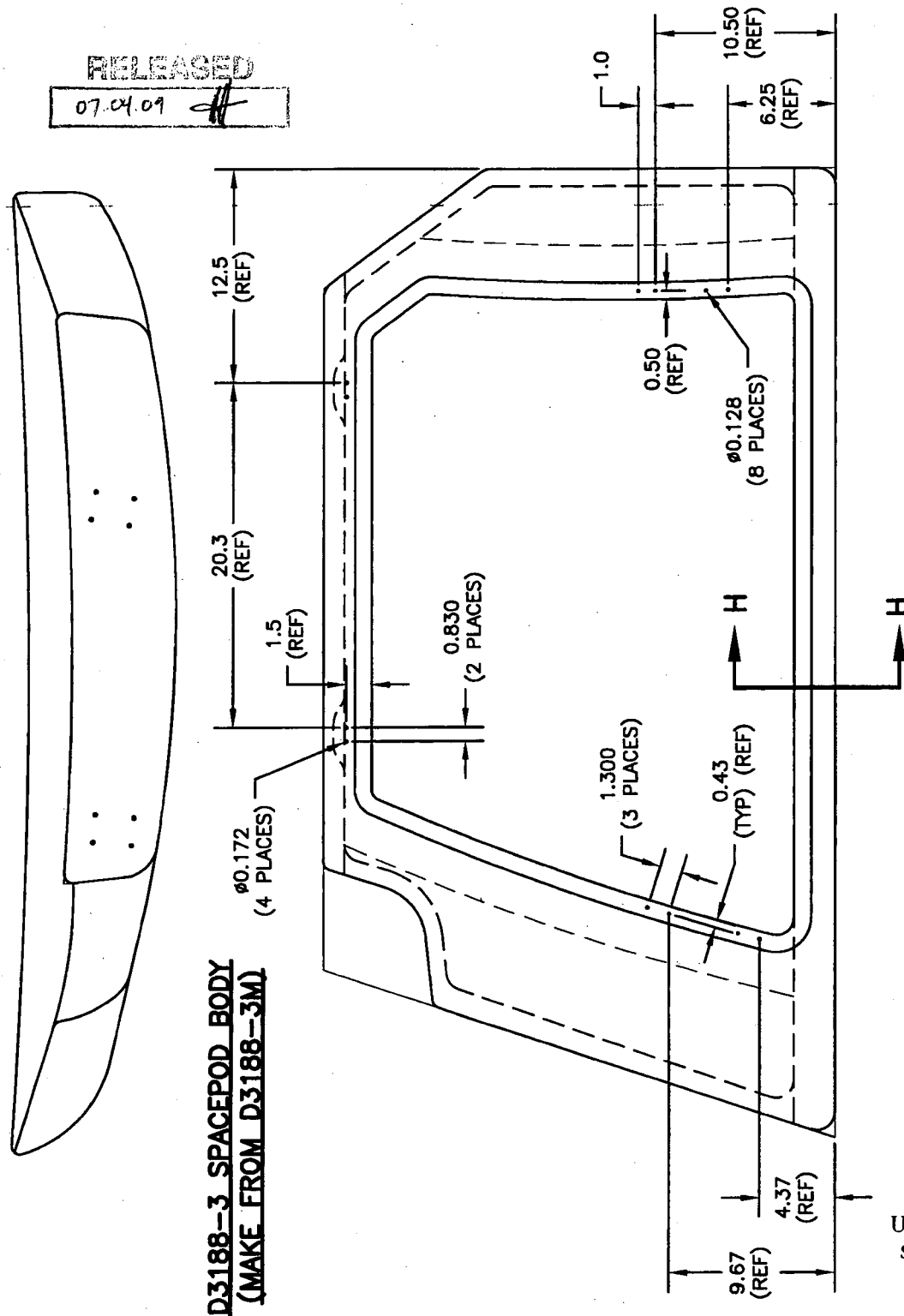
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DART

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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS

**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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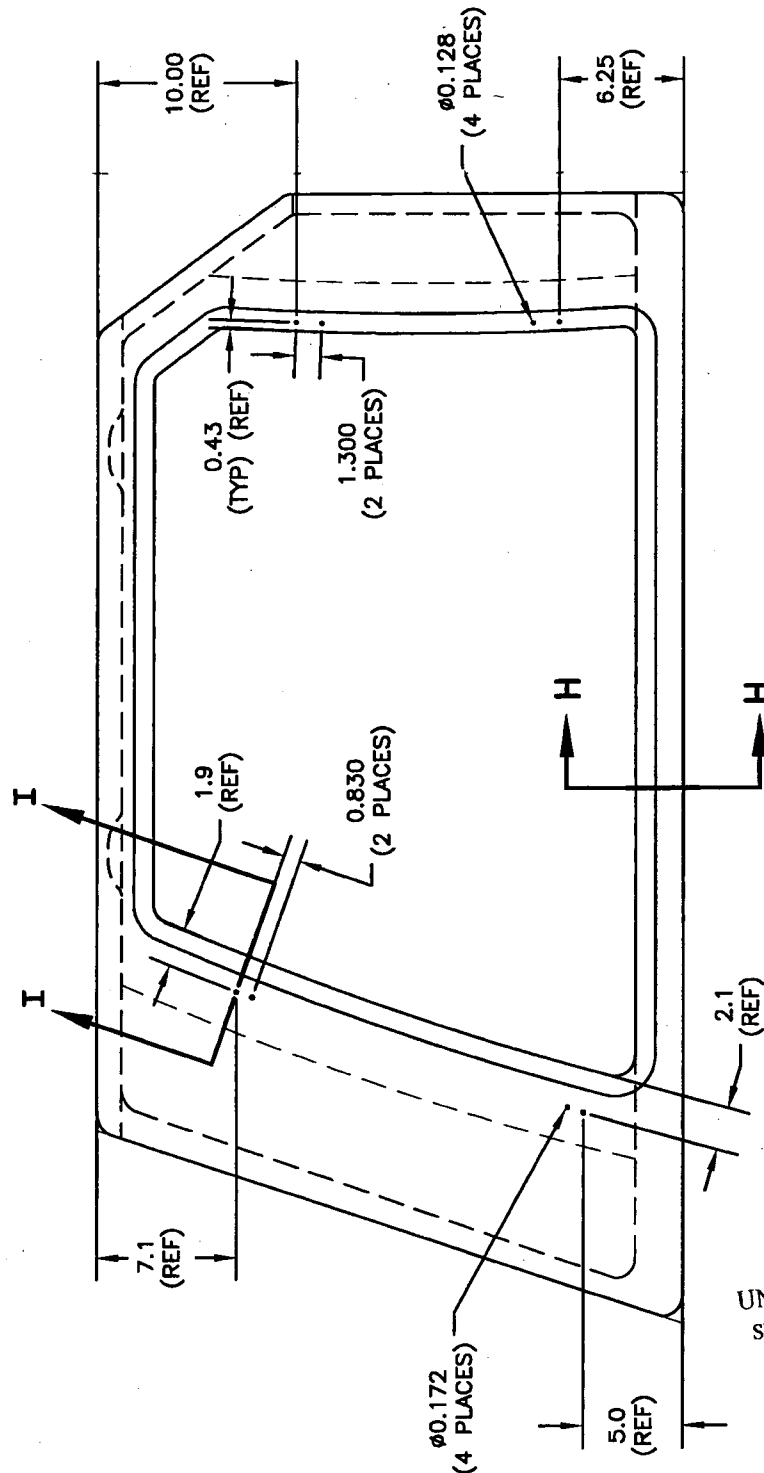
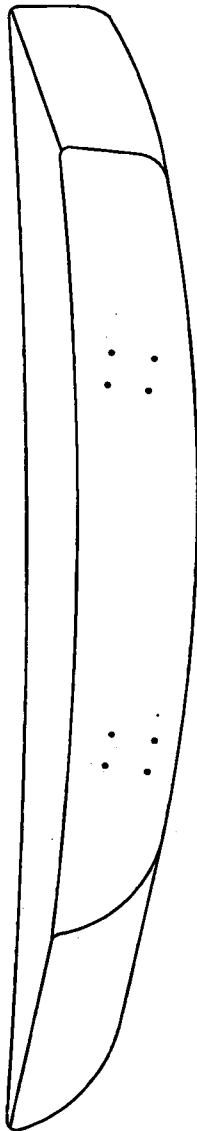
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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS

RELEASED

07.04.02

D3188-5 SPACEPOD BODY
(MAKE FROM D3188-1M)



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

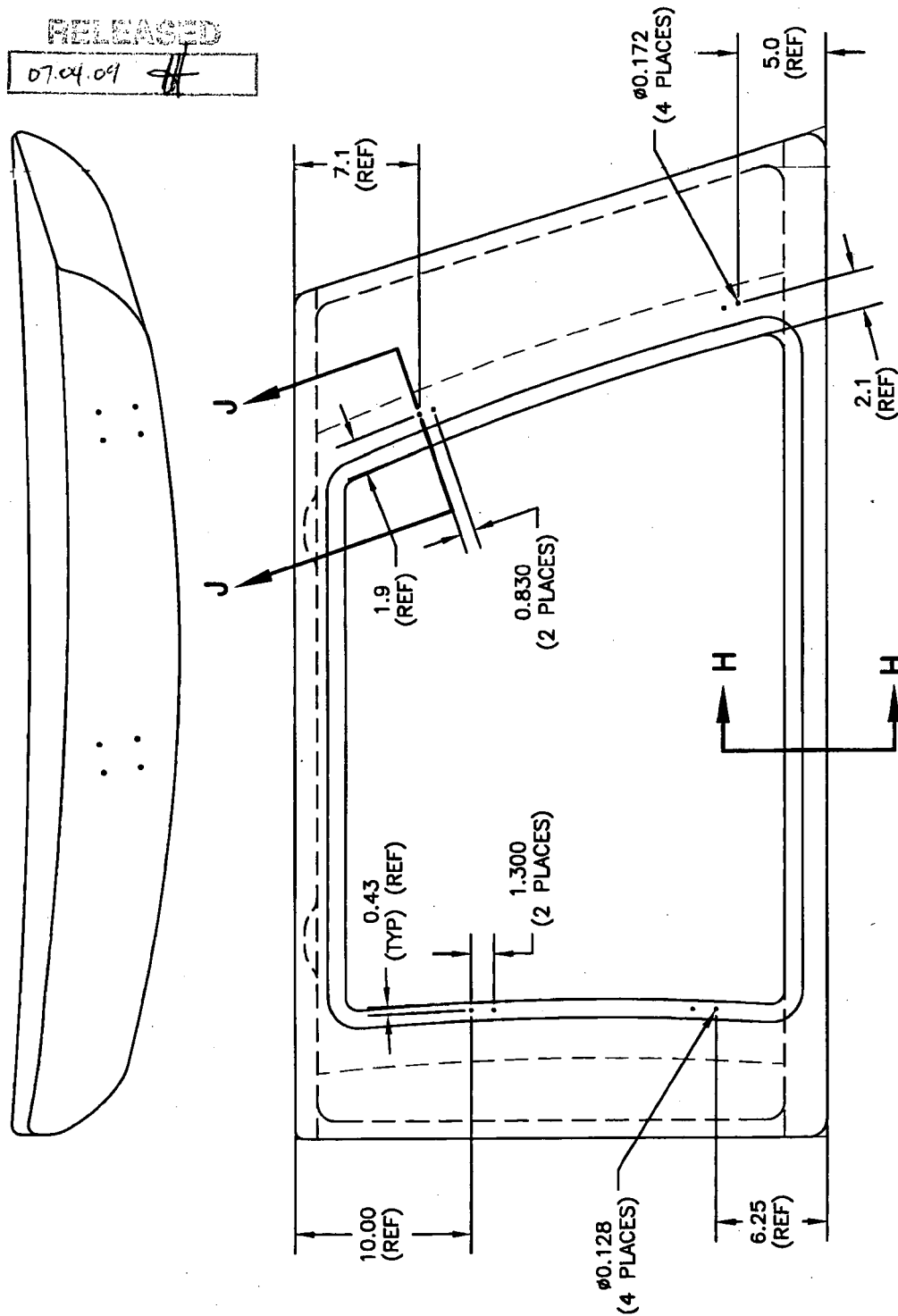
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DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS



D3188-6 SPACEPOD BODY
(MAKE FROM D3188-2M)


NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

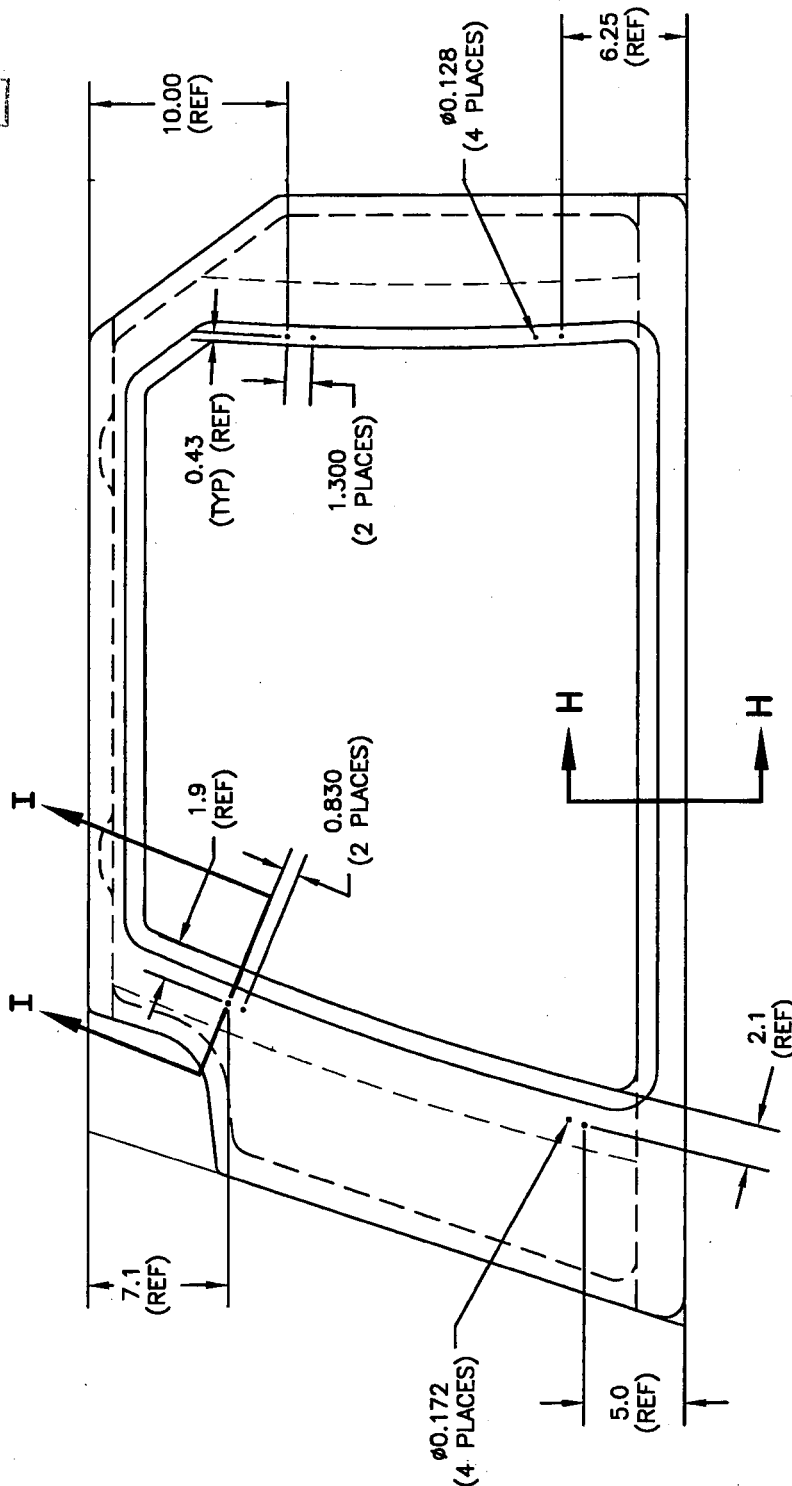
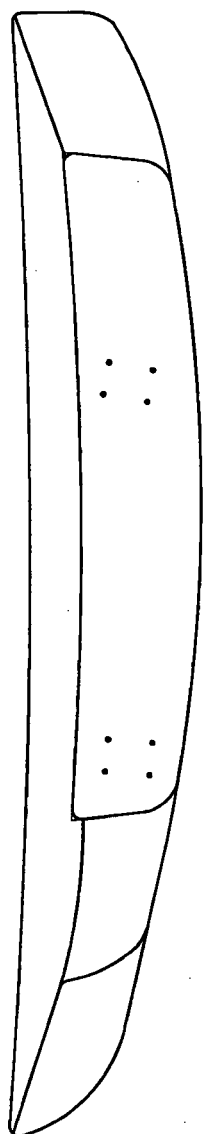
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CHECKED LE	APPROVED 	DRAWING NO. D3188	REV. E SHEET 10 OF 11
DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS

RELEASED
07.04.09 *ff*



NOTE:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE
TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS

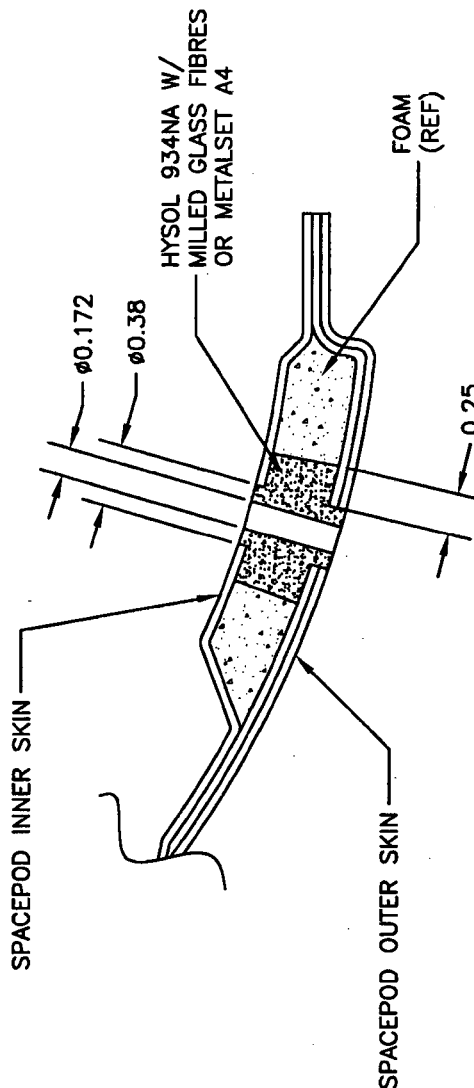
RELEASED
01.04.09 **[Signature]**

INSTALL AKS7-1032-130
INSERTS (29 PLACES)
PER D3188-1T1 (D3188-1/-3/-5/-7)
OR D3188-2T1 (D3188-2/-6)

FOAM
(REF)



SECTION H-H
(TYPICAL FLOOR SECTION)



SECTION I-I
(SECTION J-J OPPOSITE)
(4 PLACES PER POD)

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Date: Monday, 02/06/2008 4:33:22 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SPACEPOD BODY RH
Job Number :	39642A		
Estimate Number :	12596		
P.O. Number :		Part Number :	D31882M
This Issue :	02/06/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3188 REV.E
First Issue :	//	Project Number :	N/A
Previous Run :	39188A	Drawing Revision :	E
Written By :		Material :	
Checked & Approved By :	<u>JUL 08.6.02</u>	Due Date :	25/06/2008
Comment :	Est Rev:A New issue ecn882 06-11-30 EC est rev B rev D dwg 07.03.07 ec est rev C rev E dwg 07.04.16 EC		

Qty: 1 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D2213	Insert
-----	-------	--------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
 Ship To Delastek

8	D2213	Spacer
---	-------	--------

Batch:

30/07

Pc 86/4

2.0	PG	PURCHASING
-----	----	------------

**Comment:** PURCHASING

Issue P/O: 6496
 Description: D3188-2M BODY
 SHIP: D2213 Spacers
 Supplier: Delastek
 Conformity Certificate and Process sheet required
 Ship 2 Items from Previous steps

C208/06/04 ①

3.0	D31882P	Spacepod Body
-----	---------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Spacepod Body

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from Delastek is attached.

AS 08/04/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 02/06/2008 4:33:22 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD BODY RH

Job Number: 39642A

Part Number: D31882M

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3188 .Visual inspection. Check for void spot and pins.

See 08/07/24/24

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: W/O 39642

080818

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/25

Job Completion



mf 08-08-22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**RELEASED**

07.04.09

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CHECKED LE	APPROVED [Signature]	DRAWING NO. D3188	REV. E SHEET 1 OF 11
DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS
A	03.04.03	NEW ISSUE	
B	06.10.06	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7	
C	06.12.13	REMOVED D0600-XXX LABELS	
D	07.02.22	UPDATE DIMENSIONS	
E	07.04.02	ADD HYSOL/FIBER OPTION ON SHEET 11	

GENERAL NOTES:

- 1) REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
- 2) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
- 3) MATERIALS:
 - RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
 - FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLES
 - FOAM: A500 CORE CELL
OR DIVINYCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN
- 4) MOLD SCHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501
- 5) APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
- 6) FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S
- 7) ALL DIMENSIONS ARE IN INCHES
- 8) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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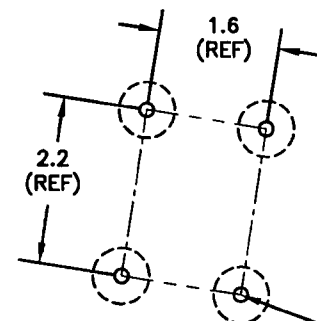
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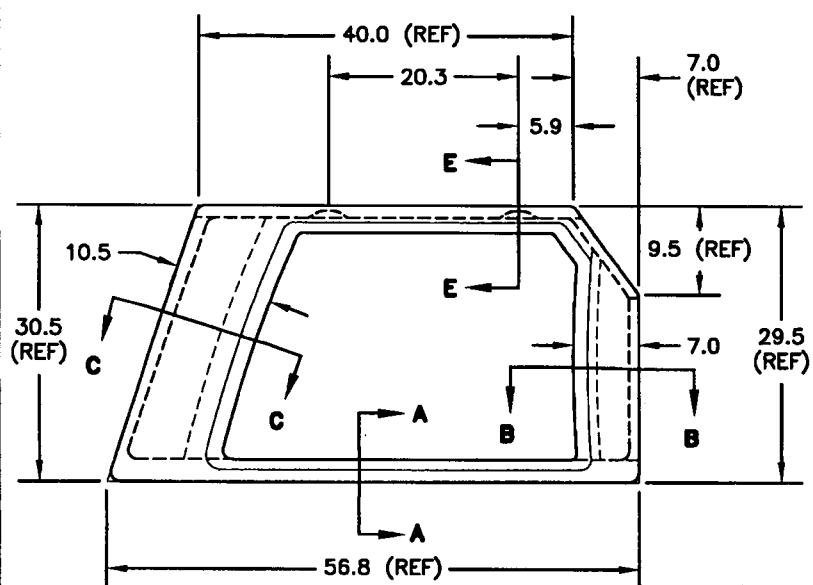
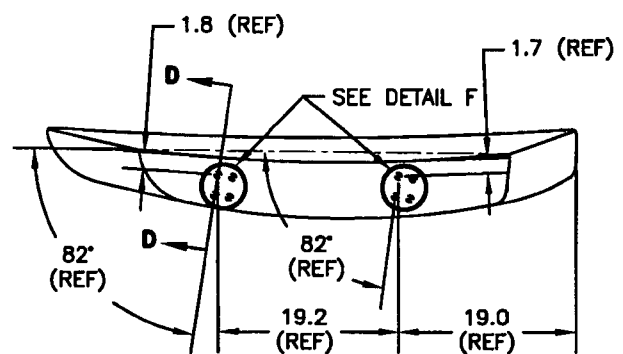
07.04.02

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DATE	07.04.02	DRAWING NO.	D3188	REV. E
		TITLE	SPACEPOD BODY	SHEET 2 OF 11
		SCALE	NTS	



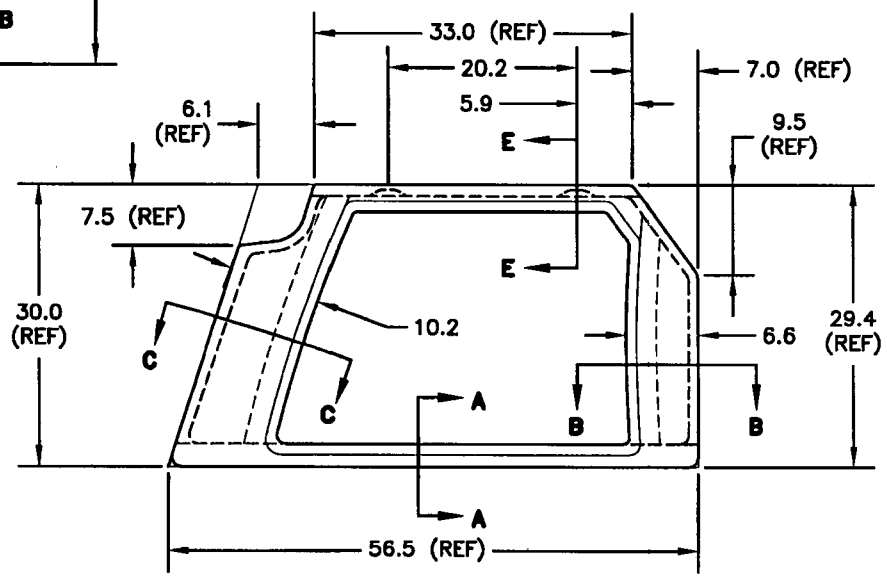
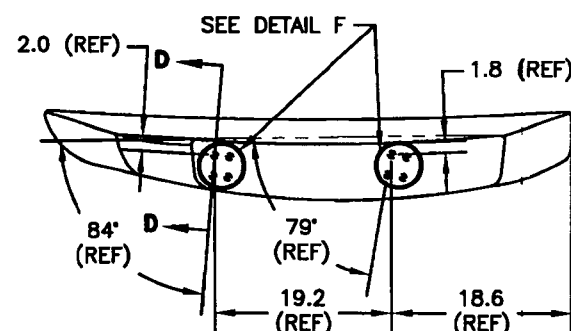
DETAIL F

INSTALL D2213 SPACER (8 PLACES) (SEE SECTION D-D)



D3188-1M SPACEPOD BODY

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D3188-3M SPACEPOD BODY

D3186-1M/-3M NOTES:

- 1) REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
- 2) SEE SHEET #4 FOR SECTION VIEWS.

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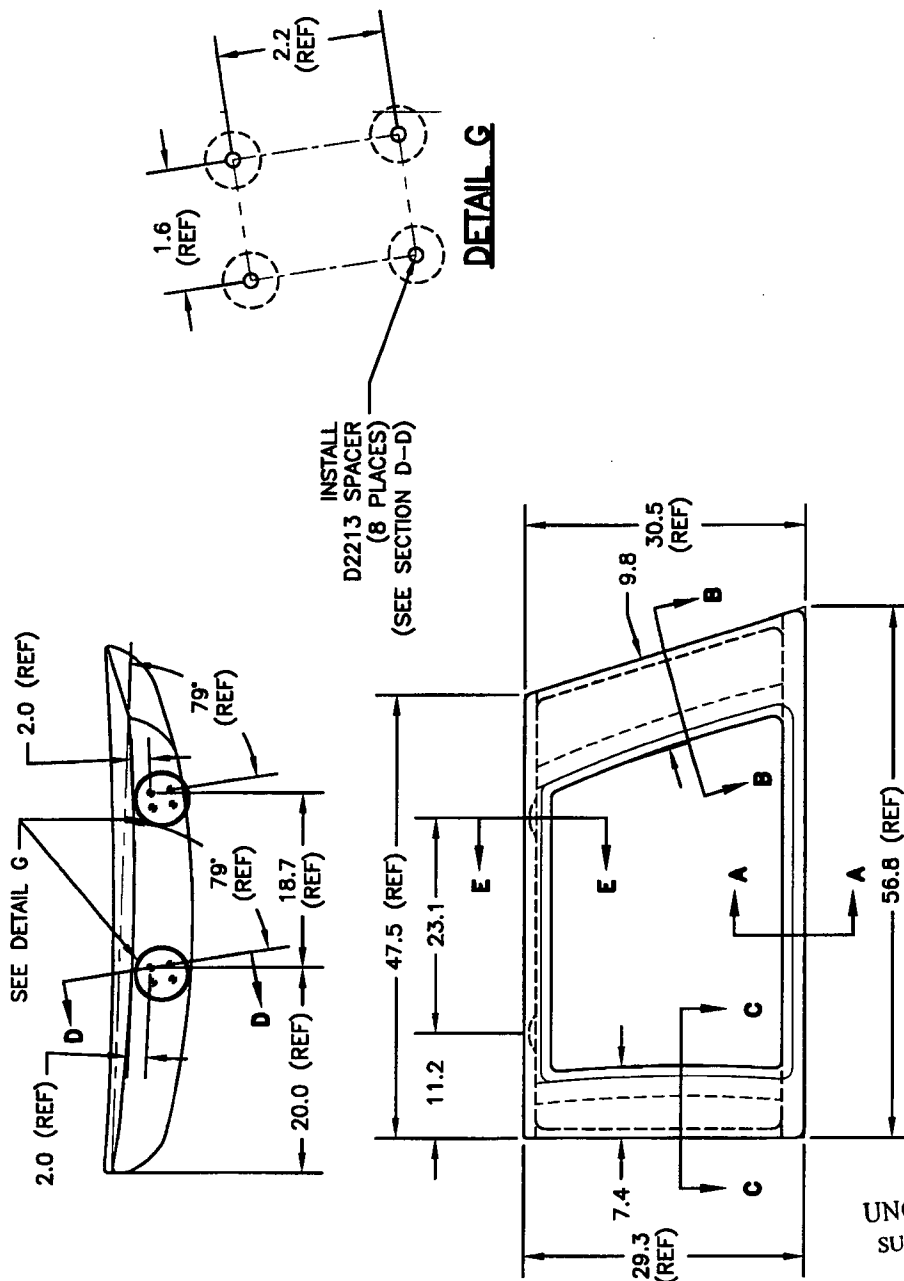
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DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS

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D3188-2M SPACEPOD BODY

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D3186-2M NOTES:
1) REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.
2) SEE SHEET #4 FOR SECTION VIEWS.

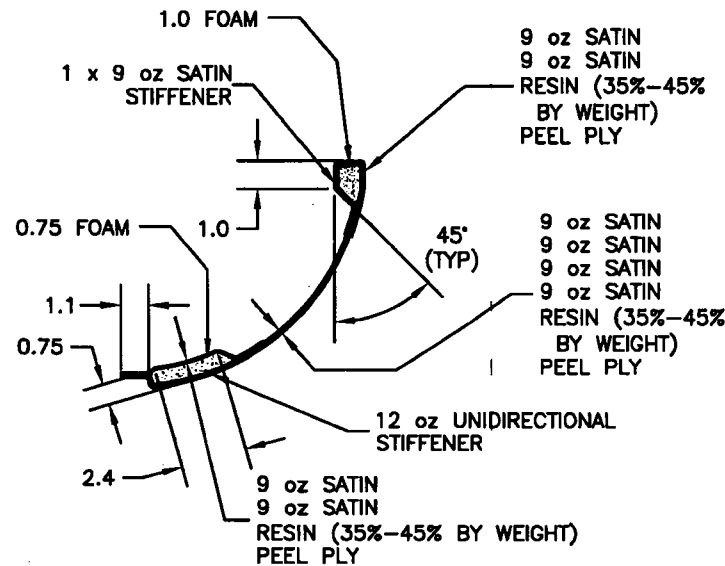
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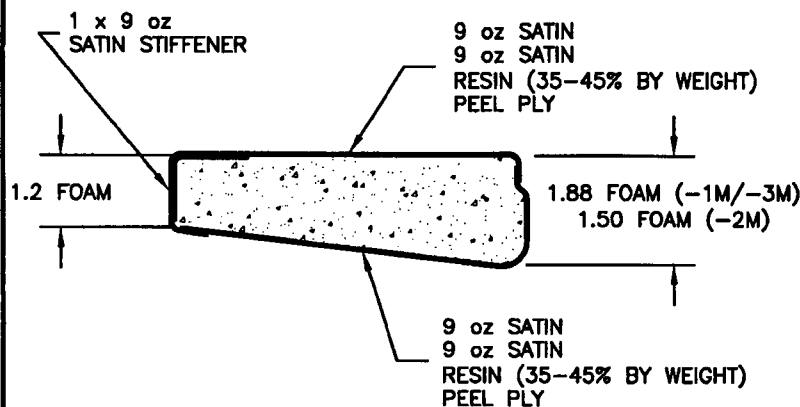
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		TITLE	SPACEPOD BODY	SHEET 4 OF 11
				SCALE
				NTS

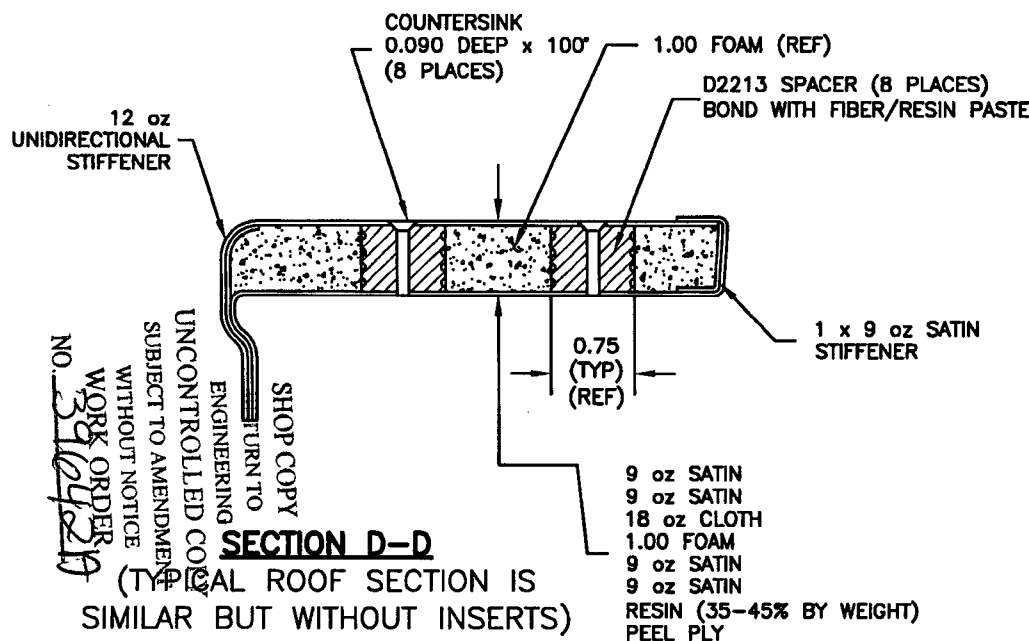
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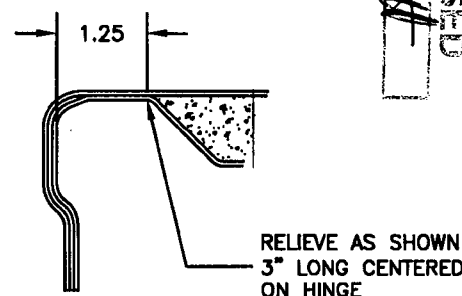
SECTION B-B
(SECTION C-C OPPOSITE)



SECTION A-A
(TYPICAL FLOOR SECTION)



SECTION D-D
(TYPICAL ROOF SECTION IS
SIMILAR BUT WITHOUT INSERTS)



SECTION E-E
(2 PLACES PER POD)

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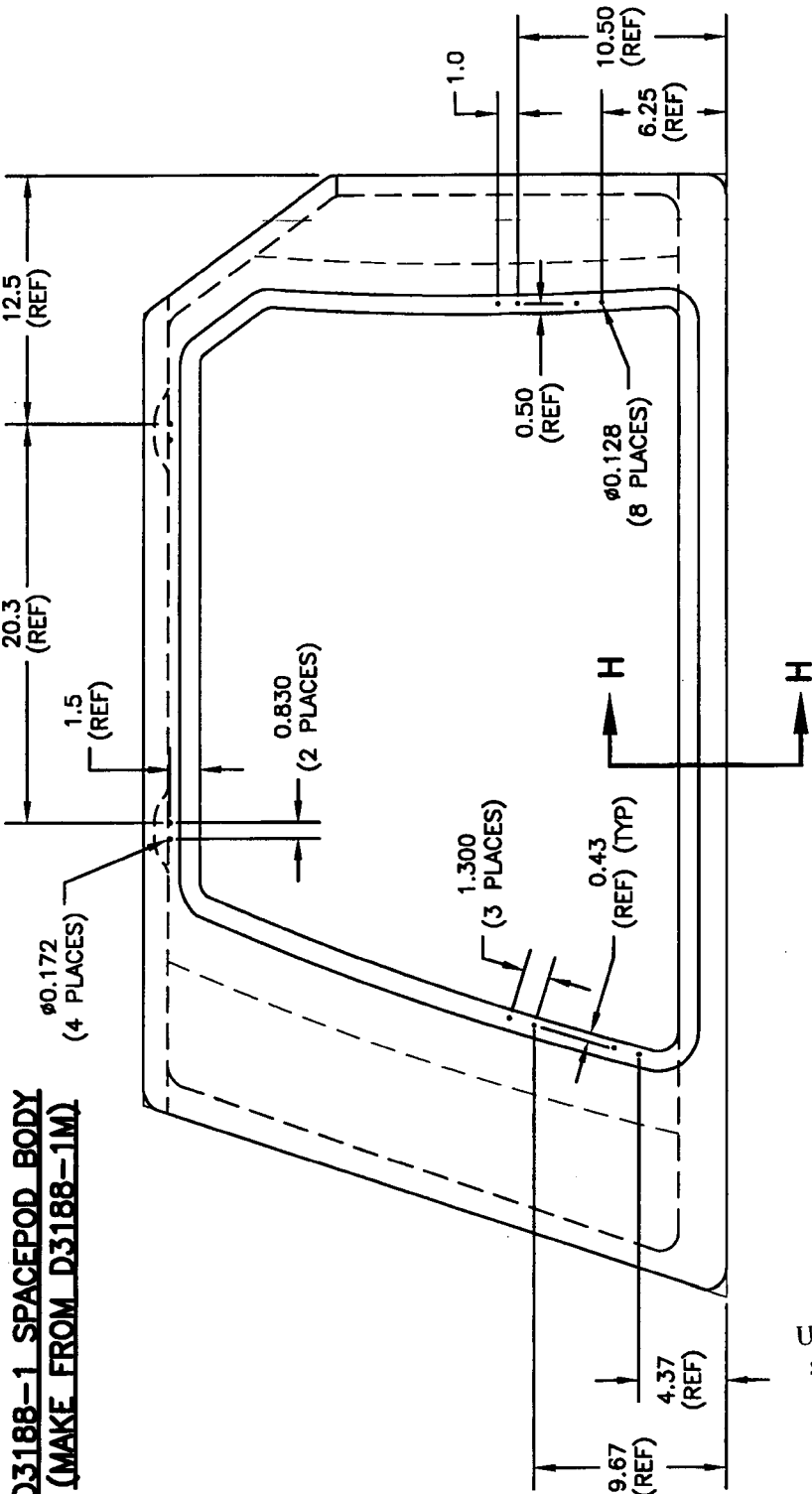
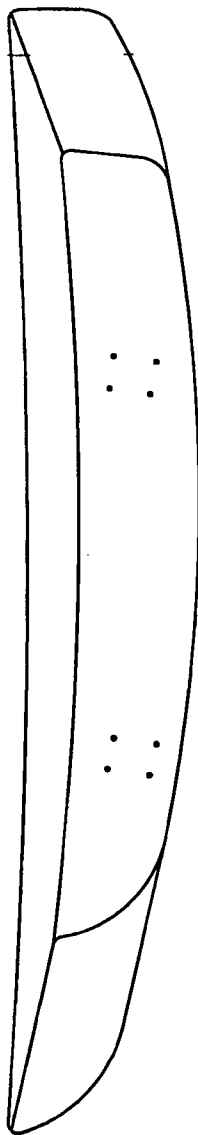
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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS

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07.04.02



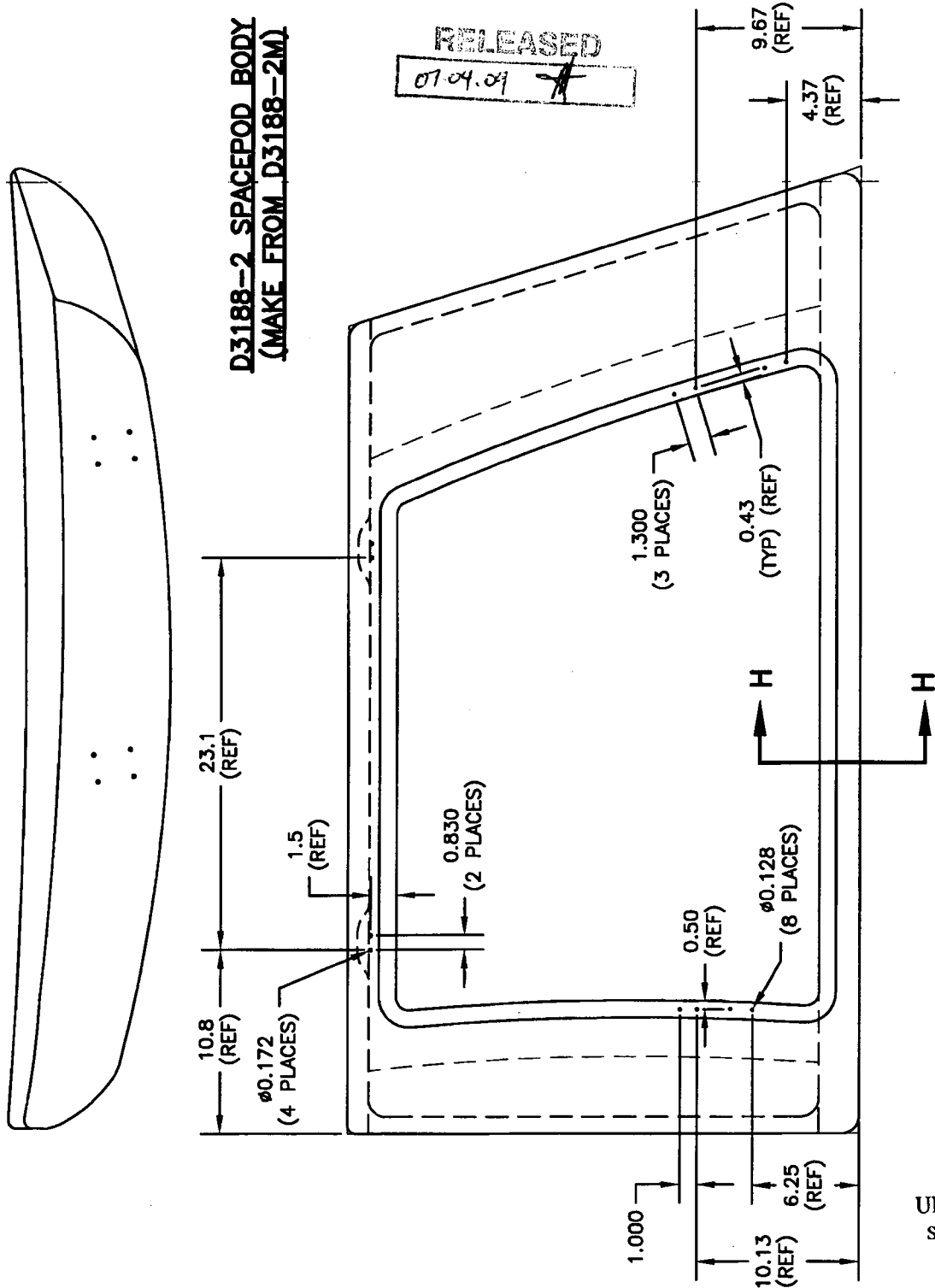
D3188-1 SPACEPOD BODY
(MAKE FROM D3188-1M)

NOTES:
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE
TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
2) SEE SHEET #11 FOR SECTION VIEW

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DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-2 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

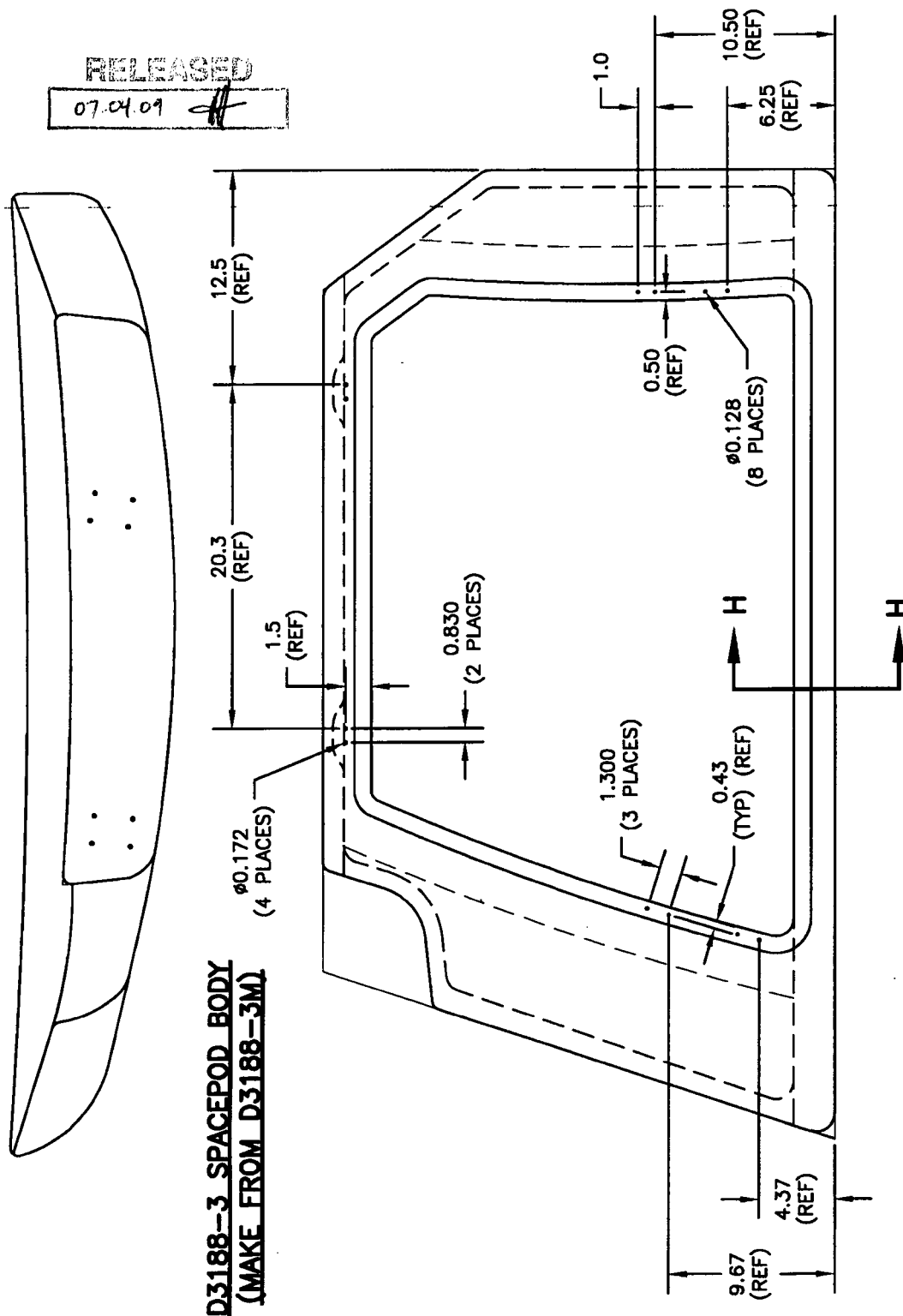
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DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS



NOTES:
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE
TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
2) SEE SHEET #11 FOR SECTION VIEW

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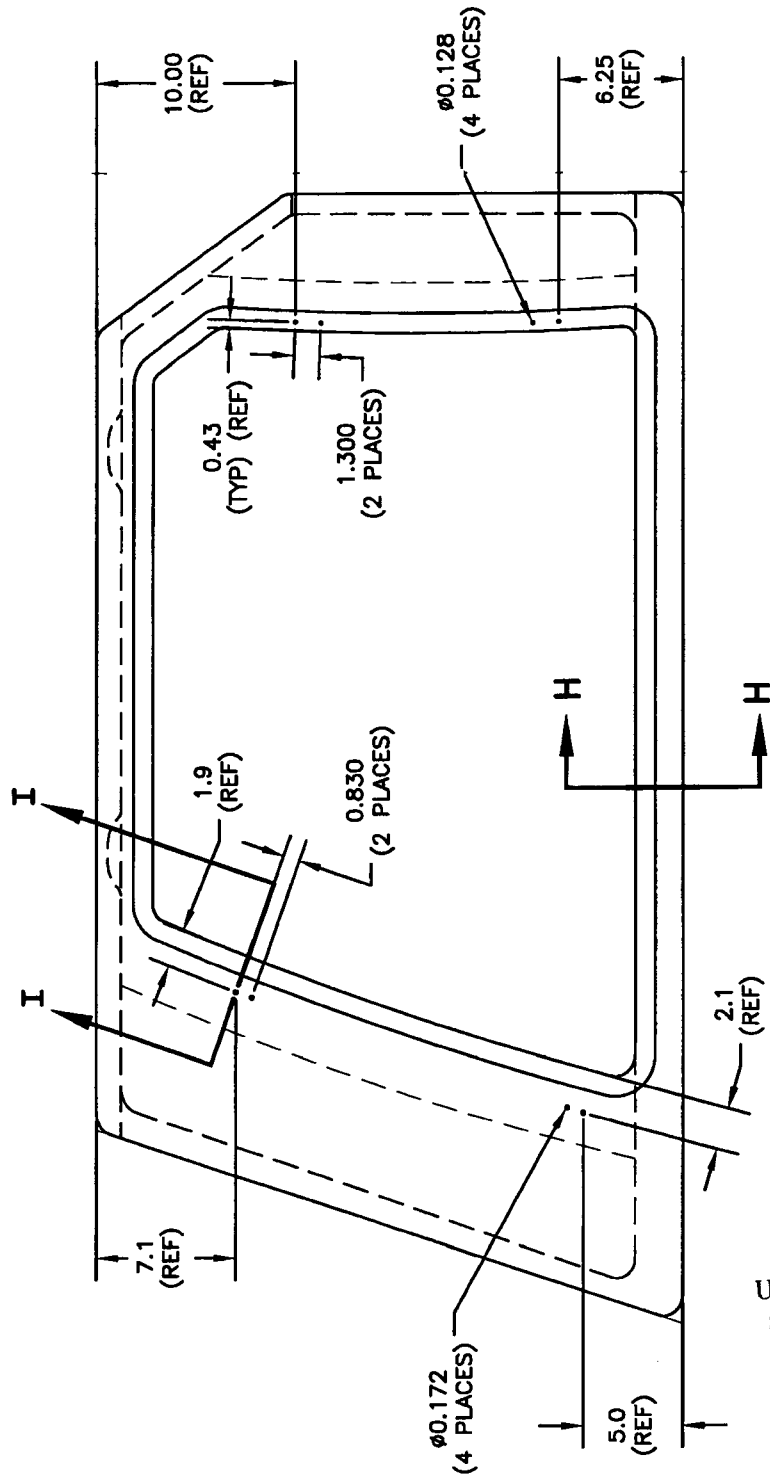
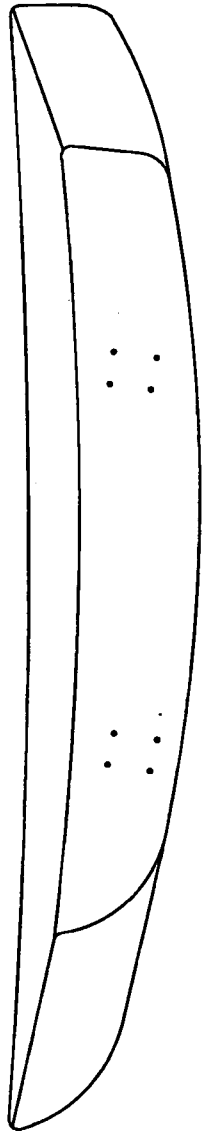


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DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS

RELEASED

07.04.02

D3188-5 SPACEPOD BODY
(MAKE FROM D3188-1M)



- NOTES:
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
 - 2) SEE SHEET #11 FOR SECTION VIEWS

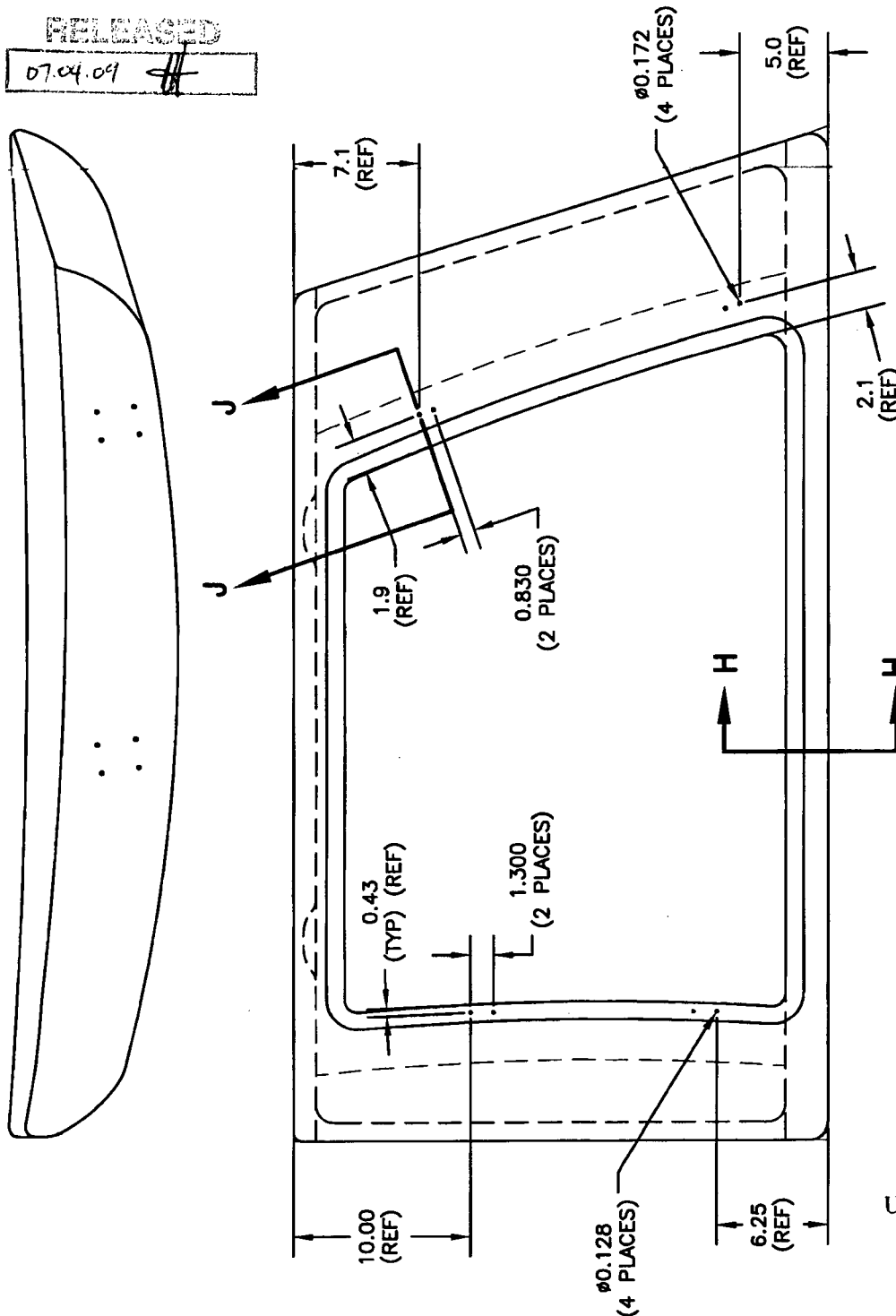
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DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS



NOTES:
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE
TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY
2) SEE SHEET #11 FOR SECTION VIEWS

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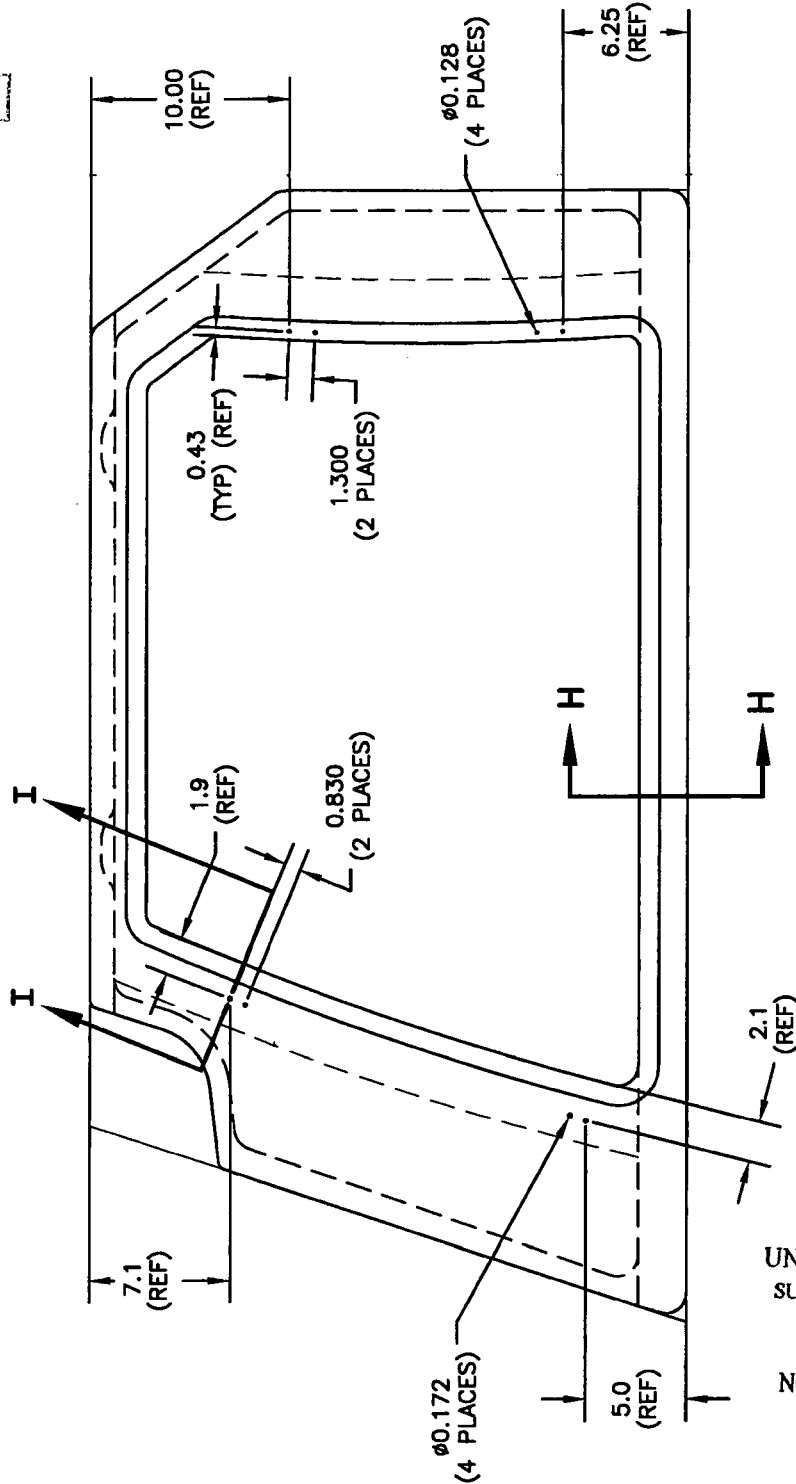
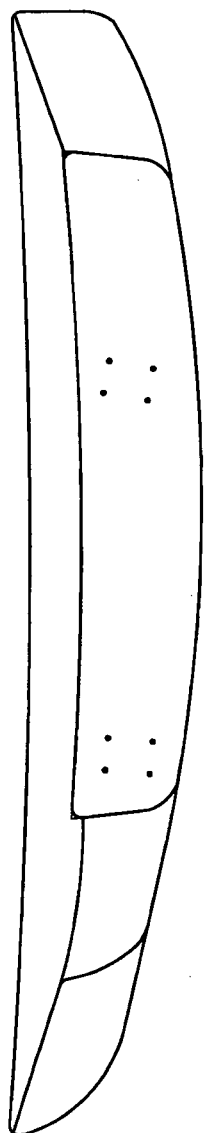
D3188-6 SPACEPOD BODY
(MAKE FROM D3188-2M)



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DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS

RELEASED
07.04.02 [Signature]

D3188-7 SPACEPOD BODY
(MAKE FROM D3188-3M)



NOTE:
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE
TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
2) SEE SHEET #11 FOR SECTION VIEWS

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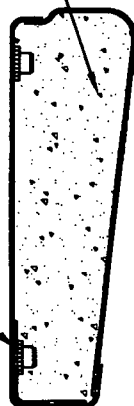
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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS

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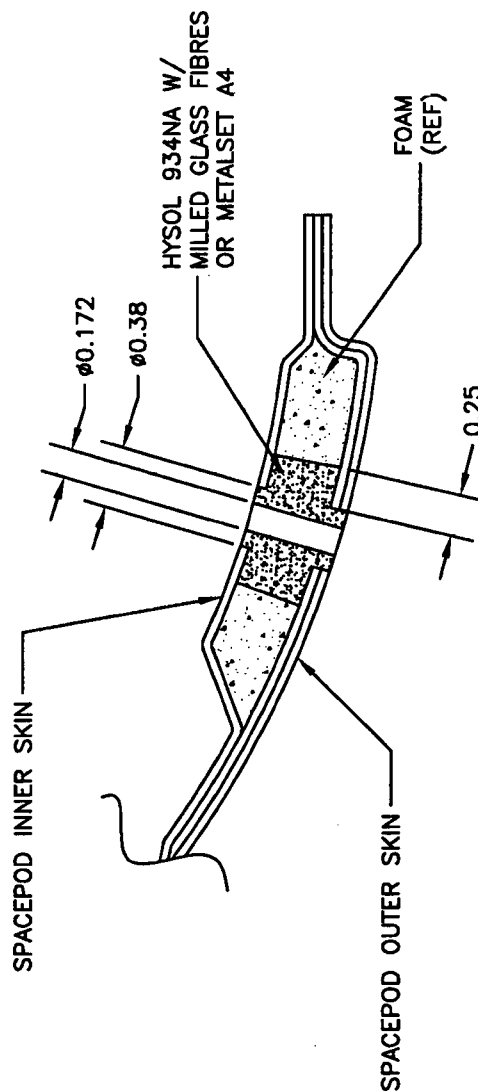
01.04.09

INSTALL AKS7-1032-130
INSERTS (29 PLACES)
PER D3188-1T1 (D3188-1/-3/-5/-7)
OR D3188-2T1 (D3188-2/-6)

FOAM
(REF)



SECTION H-H
(TYPICAL FLOOR SECTION)



SECTION I-I
(SECTION J-J OPPOSITE)
(4 PLACES PER POD)

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DELASTEK COMPOSITES INC.
2699, 5ième Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	12826
Customer #	DART

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone: 613-632-5200

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
EPIC EXPRESS COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
18/07/2008	04/06/2008	5821	C. Lavoie		PO00006496		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0055	D31882P Spacepod Body RH B39642A Dwg. Rév.: E Job: 43119 <i>Sodas</i> U de M : Each 1			
1	0	1	DKC134-0060	D31862P Spacepod Door RH B39642B0 Dwg. Rév.: D <i>8864123</i> <div><div>No. lot</div><div>43121</div></div> <div><div>Qté</div><div>1</div></div>			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by: *Martine M...*

Quality department AQ-357



Date: Jeudi, 2008-06-05 13:35:36
 Utilisateur: Marc Dubé

Feuille de Procédé

 Client : DART Dart Aerospace Ltd.
 Numéro Job : 43119
 Numéro Soumission : 2587
 Numéro B.A. :
 Cette fois : 2008-06-05 No. B.V. :
 Prsht Rev. : NC
 Prem. fois : - - Type :
 Job précédente : 42673

 Nom Dessin : SPACEPOD BODY R/H
 Numéro Article : DKC134-0055
 Numéro Dessin : D3188
 Projet Numéro : DKC134
 Révision dessin : E
 Matériel : Fibre 7781 et Résine 411-350
 Date Due : 2008-06-12 Qté: 2 Udm: UNITE

 Écrit par :
 Vérifié & Approuvé par :
 Commentaires : N° de pièce Dart Aerospace : D31882M

 RNC #2976
 i Réparation


M.M. 17-7-08


 Process Sheet Rév.: 06 Modification du planning afin d'y inclure le
 N° I.G 0008 (Primer)

Produit additionnel :

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
1.0	AC0303	Frekote 44NC
Commentair Qty.: 0.050 UNITE(s)/Unit Total : 0.100 UNITE(s) Frekote 44NC		
2.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.1667Hrs PRÉPARATION DU MOULE Faire la préparation du moule N° DT 8004 à l'aide de Frekote 44NC et laisser sécher pendant 3 heures selon le QSI-006. Date: <u>05/06/08</u> Heure Début: <u>10:44</u> Heure Fin: <u>11:20</u> Sceau: 		
3.0	AC0409	Tissu à délaminer Release ply B
Commentair Qty.: 9.84 VERGE(s)/Unit Total : 19.68 VERGE(s) Tissu à délaminer Release ply B		
4.0	AC0407	Wrightlon 5200 Bleu P3
Commentair Qty.: 9.27 VERGE(s)/Unit Total : 18.54 VERGE(s) Wrightlon 5200 Bleu P3		
5.0	AC0408	Feutre de drainage N° Airweave N 10
Commentair Qty.: 6.00 VERGE(s)/Unit Total : 12.00 VERGE(s) Feutre de drainage N° Airweave N 10		
6.0	AC0752	Stretchlon 200 poche à vide Vert
Commentair Qty.: 7.00 VERGE(s)/Unit Total : 14.00 VERGE(s) Stretchlon 200 poche à vide Vert		

Date: Jeudi, 2008-06-05 13:35:36

Préparateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY R/H

Numéro Job: 43119

Numéro Article: DKC134-0055

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
7.0	AAC0681	9.7 oz Weave #FG-778150-125Y Volan Finish

Commentaire Qty.: 11.400 VERGE(s)/Unit Total : 22.800 VERGE(s)

9.7 oz Weave #FG-778150-125Y Volan Finish

2-6476-1

8.0	AAC0443	Fiberglass 12 oz Unidirectional
-----	---------	---------------------------------

Commentaire Qty.: 0.80 VERGE(s)/Unit Total : 1.60 VERGE(s)

Fiberglass 12 oz Unidirectional

N° de Lot:

1-6258-1

9.0	AAC0633	WR1850 ROVING 18 OZ x 50"
-----	---------	---------------------------

Commentaire Qty.: 0.35 VERGE(s)/Unit Total : 0.70 VERGE(s)

WR1850 ROVING 18 OZ x 50"

N° de Lot:

1-6476-3

10.0	AC0098	Ruban à gommer jaune #: T/AT-200Y
------	--------	-----------------------------------

Commentaire Qty.: 4.0000 RL(s)/Unit Total : 8.0000 RL(s)

Ruban à gommer jaune #: T/AT-200Y

11.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
------	---------------	------------------------------



Commentaire Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 1.5000Hrs

TAILLAGE DU MATÉRIEL

Tailler le matériel, selon les différents patrons de découpe et les quantités inscrites sur ceux-ci.

À fin d'accélérer le processus de taillage, tailler les plis de 9.7 oz tous en même temps en les superposants les uns sur les autres.

Date: 16-06-08 Heure Début: 10:20 Heure Fin: 11:30 Sceau:

12.0	AAC0275	Catalyst N° DDM-9
------	---------	-------------------

Commentaire Qty.: 0.0640 PINTE(s)/Unit Total : 0.1280 PINTE(s)

Catalyst N° DDM-9

N° de Lot:

1-6270-1

13.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.
------	---------	---

Commentaire Qty.: 2.000 KILOGRAMME(s)/Unit Total : 4.000 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot:

1-2101-1

14.0	AAC0673	Fibre de verre Miapoxy 66
------	---------	---------------------------

Commentaire Qty.: 0.0039 GALLON(s)/Unit Total : 0.0078 GALLON(s)

Fibre de verre Miapoxy 66

N° de Lot: 1-5951-1

15.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
------	---------------	------------------------------



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.1667Hrs

PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantités requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: Jeudi, 2008-06-05 13:35:36

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY R/H

Numéro Job: 43119


Numéro Article: DKC134-0055

Numéro Job:



Séq.: Machine ou Opération: Description :

Préparer une seringue de 30 ml de résine chargée de fibre de verre miapoxy 66

Date: 17-6-08 Heure Début: 11:00 Heure Fin: 11:05 Sceau: 

16.0

LAMINAGE

LAMINAGE PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 3.0000Hrs


FAIRE LE LAMINAGE DES TISSUS

À l'aide de la seringue, faire un joint tout le tour de la dénivellation pour la porte directement dans le moule.

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8004 et ensuite imbiber un pli de tissu 9.7oz. et 18 oz. sur la section supérieur de la pièce.

Laminage du 12 oz.

Recommencer l'opération pour le deuxième pli.

Date: 17-6-08 Heure Début: 10:30 Heure Fin: 12:00 Sceau: 



17.0

POCHE À VIDE 1

FAIRE LA POCHE À VIDE




Commentaire Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.6667Hrs

EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: 17-6-08 Heure Début: 11:40 Heure Fin: 12:00 Sceau: 



Curing Début: 12:00 Curing Fin: 8:00

18.0

AAC0457

ATC core-cell A500 plain 4'x8' 1" thick

Commentaire Qty.: 0.75 FEUILLE(s)/Unit Total : 1.50 FEUILLE(s)











ATC core-cell A500 plain 4'x8' 1" thick Selon dessin D3188 de Dart

N° de Lot: 3-5915-2

Date: Jeudi, 2008-06-05 13:35:36

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD BODY R/H	
Numéro Job: 43119		Numéro Article: DKC134-0055	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
19.0	FAB GÉNÉRALE 3	FABRICATION GÉNÉRALE DART	
			
Commentaire Setup: 0.00Hrs/ Run: 120.0000Min Total Run : 4.0000Hrs TAILLAGE DU MATÉRIEL Tailler le Foam Core 1" selon le plan de découpe et les gabarits Date: <u>18-6-08</u> Heure Début: <u>2:35</u> Heure Fin: <u>2:40</u> Sceau: 			
20.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.	
Commentaire Qty.: 0.200 KILOGRAMME(s)/Unit Total : 0.400 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1-21011-1</u>			
21.0	AAC0275	Catalyst N° DDM-9	
Commentaire Qty.: 0.0064 PINTE(s)/Unit Total : 0.0128 PINTE(s) Catalyst N° DDM-9 N° de Lot: <u>1-6270-1</u>			
22.0	FINITION 3	FINITION PIÈCE DART	
			
Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs FINITION PIÈCE DART Prendre les deux pièces de 11" x 57" et sceller la grande surface sur chacune d'elle selon I.G. # Sceller le Foam Core.			
23.0	AAC0452	Polybond B46F	
Commentaire Qty.: 0.010 KIT(s)/Unit Total : 0.020 KIT(s) Polybond B46F N° de Lot: <u>1-6324-1</u>			
24.0	FINITION 3	FINITION PIÈCE DART	
			
Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs FINITION PIÈCE DART À l'aide du Polybond, coller ensemble les deux surfaces scellées Disposer des poind sur les pièces pour conserver une pression de collage. Laisser sécher pour un minimum de deux heures. Quantité: <u>1</u> Date: <u>18 Juin 08</u> Sceau:  			

Date: Jeudi, 2008-06-05 13:35:36

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY R/H

Numéro Job: 43119

Numéro Article: DKC134-0055

Numéro Job:



Séq.: Machine ou Opération: Description :

Quantité: _____ Date: _____ Sceau: _____

25.0


TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
TRIMAGE COMPOSITES DART

Ajuster à l'aide du thermoformeur 4" x 8" chacune des pièces de foam core dans le moule selon le dessin.

Quantité: 1 Date: 18-06-08 Sceau: 

Quantité: _____ Date: _____ Sceau: _____

26.0

AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentaire Qty.: 0.300 KILOGRAMME(s)/Unit Total : 0.600 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-21011-1

27.0

AAC0275

Catalyst N° DDM-9

Commentaire Qty.: 0.0096 PINTE(s)/Unit Total : 0.0192 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 1-6270-1

28.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 10.0000Hrs Total Run : 20.0000Hrs
PRÉPARATION DU MATÉRIEL DART

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par
quantité de résine N° 411-350 promu 75 minutes..

29.0

FAB GÉNÉRALE 3

FABRICATION GÉNÉRALE DART



Commentaire Setup: 0.00Hrs/ Run: 20.0000Hrs Total Run : 40.0000Hrs
FABRICATION GÉNÉRALE PLASTIC COMMERCIAL

Retirer les pièces de foam core du moule

Sceller les foam core à l'aide de la résine promu N° 411-350 75 minutes. Selon I.G.# Sceller le foam Core.

Laisser sécher pendant 2 heures minimum.

Date: 19-6-08 Sceau:  Initiales: CG

Date: Jeudi, 2008-06-05 13:35:36

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY R/H

Numéro Job: 43119

Numéro Article: DKC134-0055

Numéro Job:



Séq.: Machine ou Opération: Description :

30.0 AAC0452 Polybond B46F

Commentair Qty.: 0.078 KIT(s)/Unit Total: 0.156 KIT(s)

Polybond B46F

N° de Lot: 1-6324-1

31.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.1667Hrs

PRÉPARATION DU MATÉRIEL

Faire la préparation du Poly bond.

Date: 25-6-08 Heure Début: 2:25 Heure Fin: 2:35 Sceau:



32.0 ASSEMBLAGE 3 ASSEMBLAGE GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run: 2.0000Hrs

ASSEMBLAGE GÉNÉRALE DES PIÈCES

Coller les différents pièces de Foam Core dans les Spacepod Body à l'aide du Poly bond.

Date: 25-6-08 Heure Début: 2:35 Heure Fin: 2:55 Sceau:



S.V.

33.0 POCHE À VIDE 1 FAIRE LA POCHE À VIDE



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run: 0.6667Hrs

EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 2 heures minimum.

Retirer le bagging entre 1 heure et 1 heure 1/2 après le mélange de la résine afin d'enlever le surplus de polybond avant que celui-ci ne soit complètement polymérisé.

Date: 25-6-08 Heure Début: 2:55 Heure Fin: 3:05 Sceau:













Curing Début: 2:35 Curing Fin: 7:30

Date: Jeudi, 2008-06-05 13:35:36

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD BODY R/H	
Numéro Job: 43119		Numéro Article: DKC134-0055	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
34.0	AC0058	Polysoft 1.3 kg # 003012 Sikkens	
Commentaire Qty.: 0.100 UNITE(s)/Unit Total : 0.200 UNITE(s) Polysoft 1.3 kg # 003012 Sikkens			
N° de Lot: <u>1-6284-1</u>			
35.0	AC0059	Durcisseur Polysoft #004009 Sikkens	
Commentaire Qty.: 0.078-UNITE(s)/Unit Total : 0.156 UNITE(s) Durcisseur Polysoft #004009 Sikkens			
36.0	FINITION 3	FINITION PIÈCE DART	
			
Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 1.0000Hrs FINITION GÉNÉRALE			
Corriger les petits défauts de surface de la pièce avec du Sikkens. Pour les plus gros défauts utiliser du polybond			
Date: <u>26-6-08</u> Heure Début: <u>10:15</u> Heure Fin: <u>11:00</u> Sceau: 			
37.0	TRIMAGE 3	TRIMAGE COMPOSITES DART	
			
Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs TRIMAGE COMPOSITES DART			
26-6-08 			
Tailler le foam core afin d'ajuster le contour de la pièce à celui du moule.			
38.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.	
Commentaire Qty.: 0.100 KILOGRAMME(s)/Unit Total : 0.200 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min.			
N° de Lot: <u>1-21011-1</u>			
39.0	AAC0275	Catalyst N° DDM-9	
Commentaire Qty.: 0.0032 PINTE(s)/Unit Total : 0.0064 PINTE(s) Catalyst N° DDM-9			
N° de Lot: <u>1-6270-1</u>			
40.0	FINITION 3	FINITION PIÈCE DART	
			
Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs FINITION PIÈCE DART			
26-6-08 			
Sceller le foam core qui a été exposé suite au taillage précédent selon I.G. # Sceller le Foam Core			
Laisser sécher pendant minimum deux heures.			

Date: Jeudi, 2008-06-05 13:35:36

Utilisateur: Marc Dubé

Feuille de Procédé

Cliant: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY R/H

Numéro Job: 43119

Numéro Article: DKC134-0055

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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41.0	AAC0275	Catalyst N° DDM-9
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Commentair Qty.: 0.0504 PINTE(s)/Unit Total: 0.1008 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 1-6270-1

42.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.
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Commentair Qty.: 1.500 KILOGRAMME(s)/Unit Total: 3.000 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.


N° de Lot: 1-21143-1

43.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
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Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.1667Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 2008-06-05 Heure Début: 9:40 Heure Fin: 9:50 Sceau: 




44.0	INSPECTION 3	INSPECTION PIÈCE DART
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Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run: 3.0000Hrs
FAIRE LE LAMINAGE DES TISSUS

Laminer deux pli de 9.7 oz 7781 partout dans le moule.

Le laminage doit être fait à l'aide de la résine N° 411-350 / 2% DDM-9.

Date: 2008-06-05 Heure Début: 10:15 Heure Fin: 11:10 Sceau:   

45.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE
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Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run: 0.6667Hrs
EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: Jeudi, 2008-06-05 13:35:36

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY R/H


Numéro Job: 43119

Numéro Article: DKC134-0055

Numéro Job:



Séq.: Machine ou Opération: Description :

Date: 2008-06-05 Heure Début: 11:10 Heure Fin: 11:25 Sceau: 

Curing Début: 10:15 Curing Fin: 3:30

46.0

DÉMOULAGE 1


DÉMOULAGE PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 1.0000Hrs

DÉMOULAGE DES PIÈCES

Démouler la pièce en se servant de la prise d'air sous le moule en faisant bien attention de ne pas abimer les différentes surfaces de la pièce.

Date: 2008-06-08 Heure Début: 3:30 Heure Fin: 4:00 Sceau: 

47.0

TRIMAGE 3

TRIMAGE COMPOSITES DART




Commentaire Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 2.0000Hrs

TRIMAGE DE FINITION

Perçer les 8 trous sur la section supérieur de la pièce ainsi que l'ouverture pour la porte à l'aide du gabarit N° DT5802.

Par l'intérieur, perçer les 8 dégagement de $\varnothing .745"$ pour les spacers N° D2213 (ne pas perçer la peau extérieur de la pièce)

Date: 4-7-08 Heure Début: 12:30 Heure Fin: 1:30 Sceau: 

48.0

AAC0275

Catalyst N° DDM-9

Commentaire Qty.: 0.0048 PINTE(s)/Unit Total : 0.0096 PINTE(s)

Catalyst N° DDM-9

N° de Lot: 1-6270-1



49.0

AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentaire Qty.: 0.150 KILOGRAMME(s)/Unit Total : 0.300 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-21143-1  1-2956-1  (3M K-20)

50.0

AAC0673

Fibre de verre Miapoxy 66

Commentaire Qty.: 0.0420 GALLON(s)/Unit Total : 0.0840 GALLON(s)

Fibre de verre Miapoxy 66

N° de Lot: 1-2956-1 (3M K-20)

Date: Jeudi, 2008-06-05 13:35:37

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY R/H

Numéro Job: 43119

Numéro Article: DKC134-0055

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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51.0


PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.1667Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 4-7-08 Heure Début: 1:30 Heure Fin: 1:35 Sceau: 

52.0

AAC0448

Spacer N° D2213

Commentair Qty.: 8 UNITE(s)/Unit Total : 16 UNITE(s)

Spacer N° D2213

N° de Lot: 1-6650-1

53.0

ASSEMBLAGE 3

ASSEMBLAGE GÉNÉRALE DART




Commentair Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 1.5000Hrs
ASSEMBLAGE GÉNÉRALE DES PIECES

Faire l'assemblage des inserts (Spacer) N° D2213 dans les trous prévus à cet effet à l'aide de résine N° 411-350 chargé à l'aide de Fibre de verre courte Miapoxy 66.

Laminer un pièce de 9 oz. sur chacune des 2 zones de 4 spacers pour reboucher les trous

Appliquer un pression sur les pièces de 9 ox à l'aide d'un bloc de bois et de pinces autobloquantes

Laisser sécher pendant 4 heures minimum.

Date: 4-7-08 Heure Début: 12:30 Heure Fin: 1:30 Sceau: 

Curing Début: 1:30 Curing Fin: 7:30

54.0

AAC0275

Catalyst N° DDM-9

Commentair Qty.: 0.0096 PINTE(s)/Unit Total : 0.0192 PINTE(s)

Catalyst N° DDM-9

N° de Lot: 1-6270-1

55.0

AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.300 KILOGRAMME(s)/Unit Total : 0.600 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-211430-1

Date: Jeudi, 2008-06-05 13:35:37

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY R/H

Numéro Job: 43119

Numéro Article: DKC134-0055

Numéro Job:



Séq.: Machine ou Opération: Description :

56.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.1667Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% de Catalyst N° DDM-9 par
quantité de résine N° 411-350.

Date: 4-7-06 Heure Début: 9:00 Heure Fin: 9:05 Sceau:

57.0 LAMINAGE LAMINAGE PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 55.0000Min Total Run : 1.8333Hrs
FAIRE LE LAMINAGE DES TISSUS

Retirer les pinces et blocs de bois

Faire le laminage d'un pli de 9.7 oz 7781 sur le contour de la pièce. Selon le dessin.

Laisser sécher pendant 4 heures minimum.

Date: 4-7-08 Heure Début: 9:05 Heure Fin: 9:55 Sceau: Curing Début: 9:05 Curing Fin: 3:30

58.0 FINITION 3 FINITION PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
FINITION PIÈCE DART

Repercer les 8 trous des spacers afin de les déboucher

Sabler les surfaces de la pièce pour aider à l'adhésion du primer et enlever les imperfections.

59.0 AAC0683 Dupont Primer N° 7704S

Commentaire Qty.: 0.5000 UNITE(s)/Unit Total : 1.0000 UNITE(s)
Dupont Primer N° 7704S N° de Lot: 1-6574-1

60.0 AAC0685 Dupont Activator - Reducer Chromabase N° 7775S

Commentaire Qty.: 0.0283 UNITE(s)/Unit Total : 0.0566 UNITE(s)
Dupont Activator - Reducer Chromabase N° 7775S 1-21248-1

Date: Jeudi, 2008-06-05 13:35:37
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 43119

Nom Dessin: SPACEPOD BODY R/H
Numéro Article: DKC134-0055

Numéro Job:



Séq.:

Machine ou Opération:

Description :

61.0

PRIMER

APPLICATION DE PRIMER



Commentaire Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
APPLICATION DE PRIMER

Appliquer le primer selon I.G. 0008

Quantité: 1 Date: 10-08-07 Sceau:

Quantité: 1 Date: JUL 11 2008 Sceau:

Quantité: 1 Date: 17-07-08 Sceau: M.A

Quantité: _____ Date: _____ Sceau: _____

62.0

INSPECTION 3

INSPECTION PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.5000Hrs
INSPECTION GÉNÉRALE

Faire l'inspection générale de la pièces selon le dessin par le département de la qualité.

Date: 15-7-08 Sceau: Initiales: M.M.

#RNC: 2976
M.M.
17-7-08

63.0

EMBALLAGE 3

EMBALLAGE PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
EMBALLAGE PIÈCE DART

Faire l'emballage dans le contenant approprié.

Quantité: 1 Date: 18-07-08 Sceau:

Quantité: _____ Date: _____ Sceau: _____

Date: Monday, 02/06/2008 4:33:22 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACEPOD DOOR RH
Job Number : 39642B	
Estimate Number : 12636	
P.O. Number :	Part Number : D31864
This Issue : 02/06/2008 S.O. No. :	Drawing Number : D3186 REV.D
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : D
Previous Run : 39188B	Material :
Written By :	Due Date : 25/06/2008 Qty: 1 Um: Each
Checked & Approved By : <u>JUL 08-6-08</u>	
Comment : Est Rev:A New Issue 07-01-11 EC est rev.B revD 07.03.07 ec	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	39642B01	SPACEPOD DOOR RH
-----	----------	------------------

**Comment:** Sub-Component SPACEPOD DOOR RH

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------

**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Drill holes and cut out slots for latch as per dwg D3186 (D3186-4 detail)

A 080812

3.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------

**Comment:** INSPECT WORK TO CURRENT STEP

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: W/O 39642

A 080818

5.0	QC21	FINAL INSPECTION/W/O RELEASE
-----	------	------------------------------

**Comment:** FINAL INSPECTION/W/O RELEASE

08/08/25 A

Job Completion



MF 08-08-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

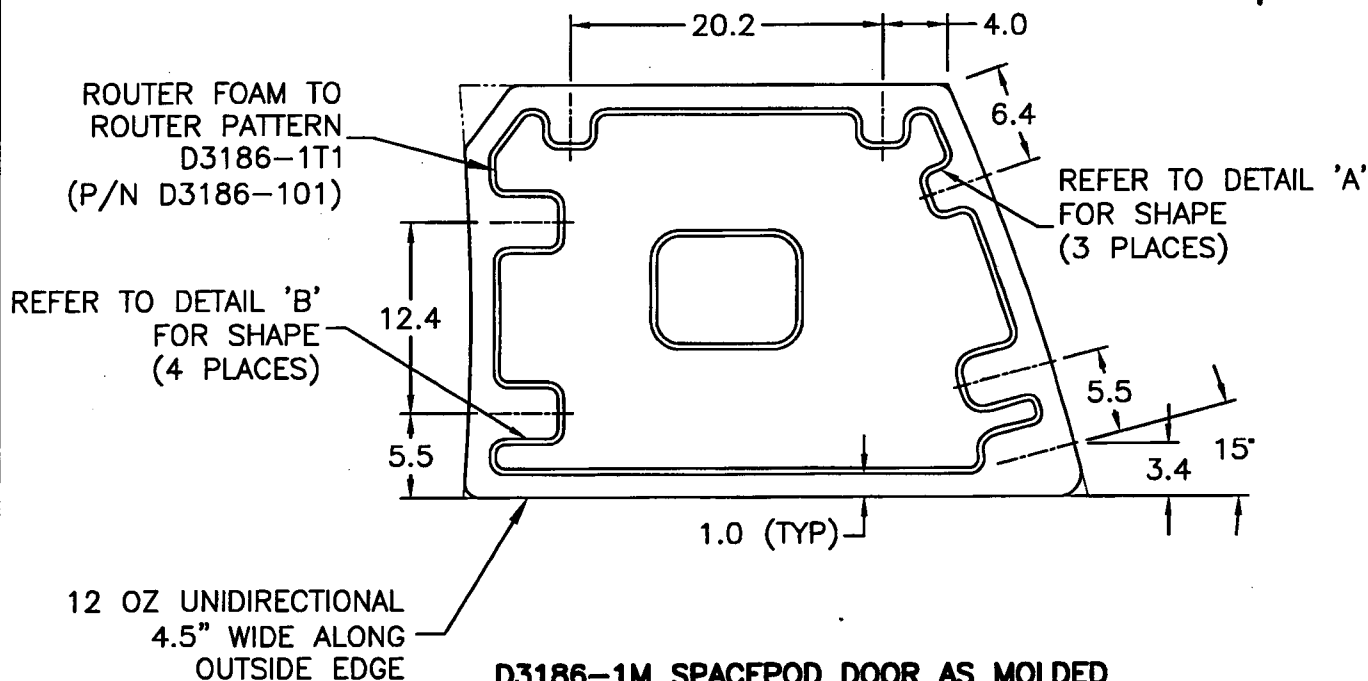
DESIGN DS	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JB	APPROVED H	DRAWING NO. D3186	REV. D SHEET 1 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS
A	03.03.27	NEW ISSUE	
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	
C	06.12.13	REMOVED D0600-XXX LABELS	
D	07.02.22	UPDATE DIMENSIONS	

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

RELEASED

07.02.27

**D3186-1M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYLCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
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WITHOUT NOTICE
WORK ORDER
NO. 39642B

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DART

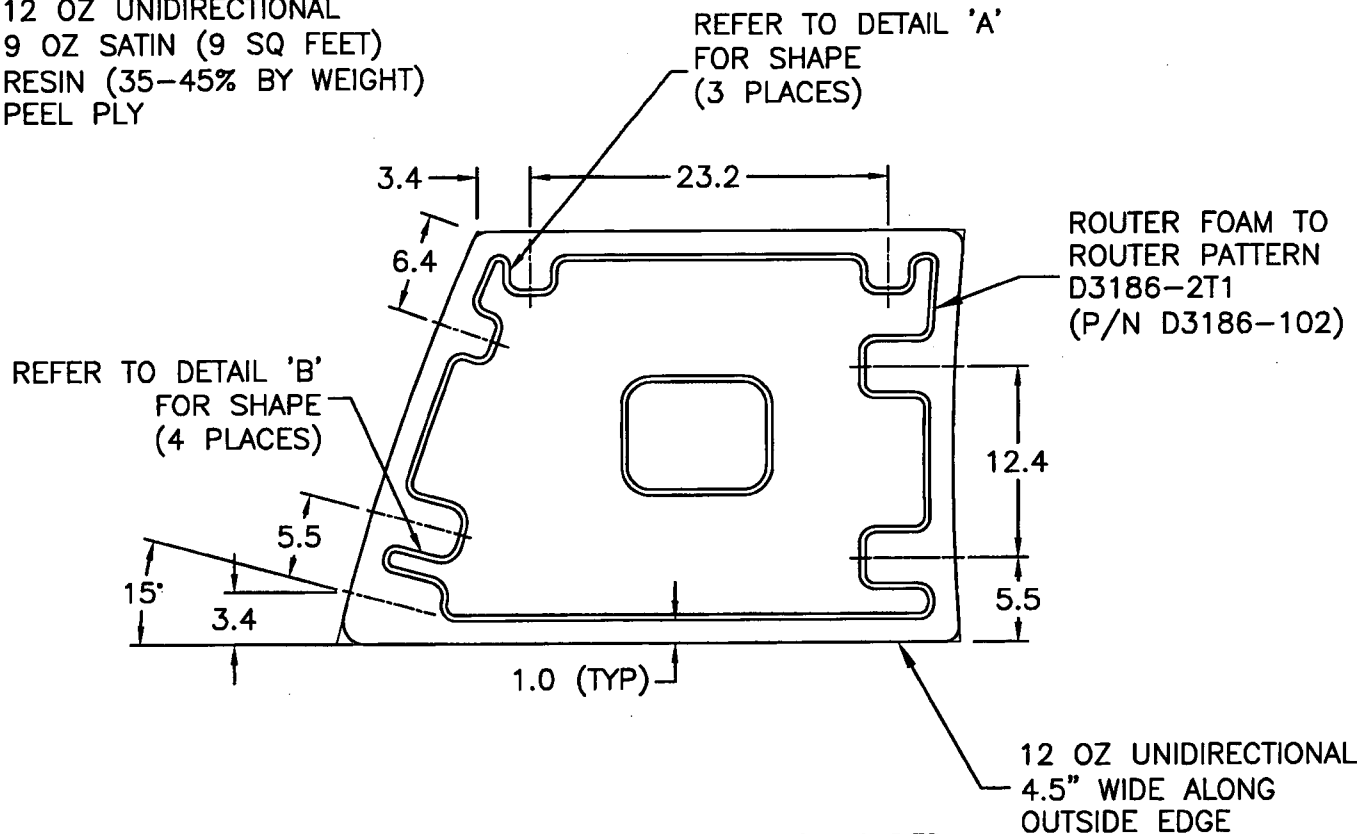
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3186	REV. D SHEET 2 OF 5
DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

RELEASED

07.02.27 [Signature]

**D3186-2M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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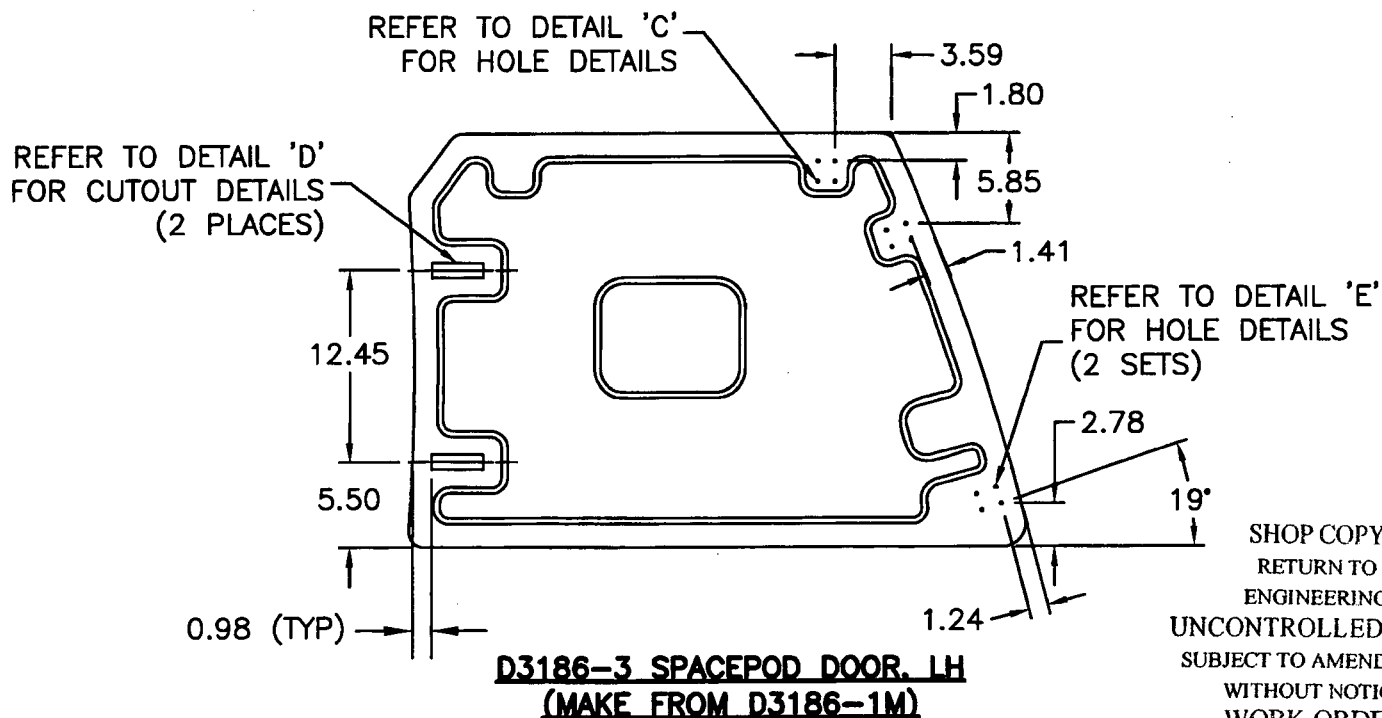
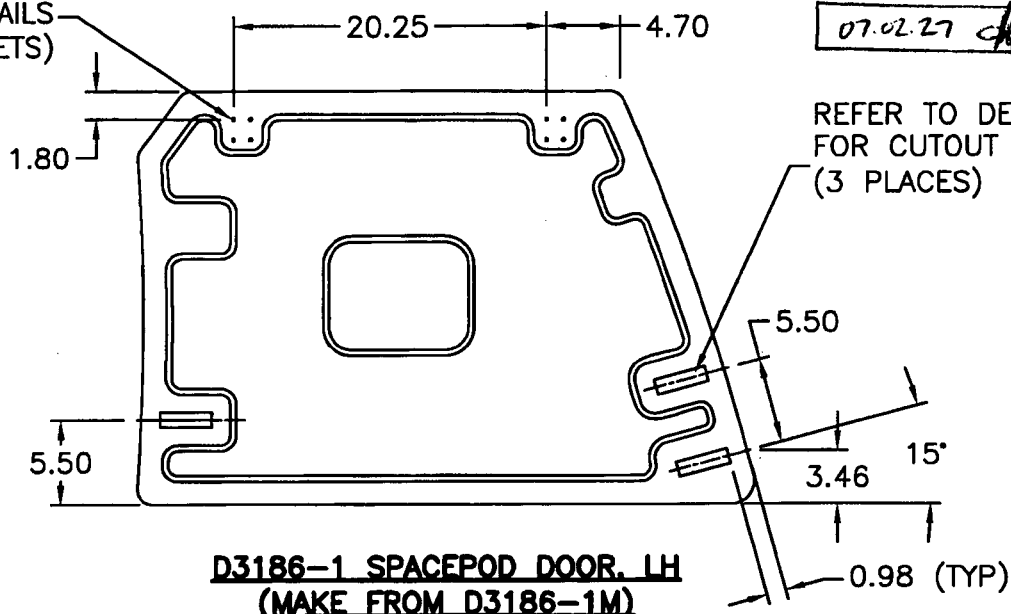
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DART

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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3186	REV. 0 SHEET 3 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

REFER TO DETAIL 'C'
FOR HOLE DETAILS
(2 SETS)

**NOTES:**

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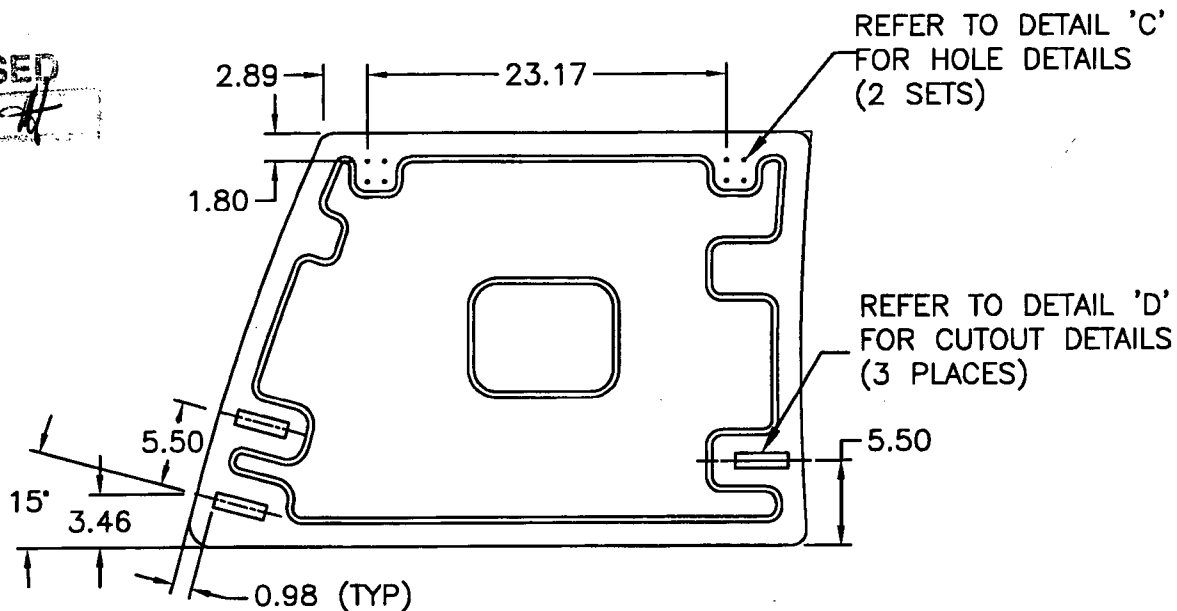
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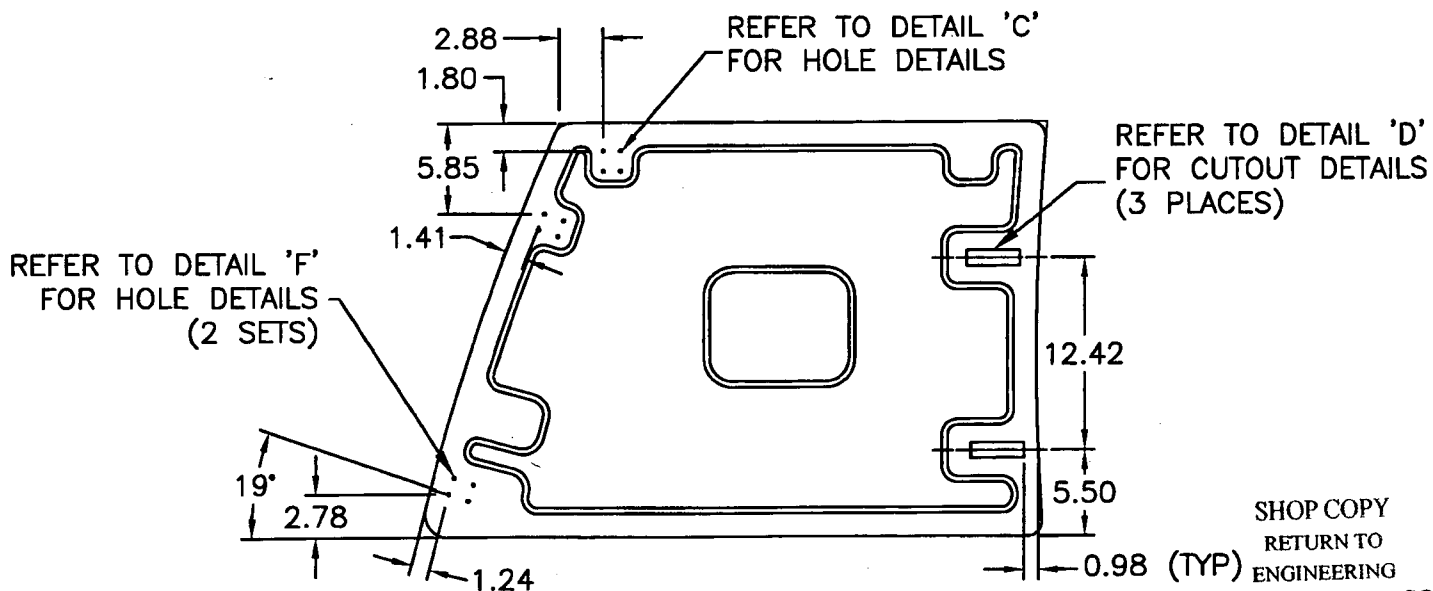


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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

RELEASED
07.02.27



D3186-2 SPACEPOD DOOR, RH
(MAKE FROM D3186-2M)



D3186-4 SPACEPOD DOOR, RH
(MAKE FROM D3186-2M)

NOTES:

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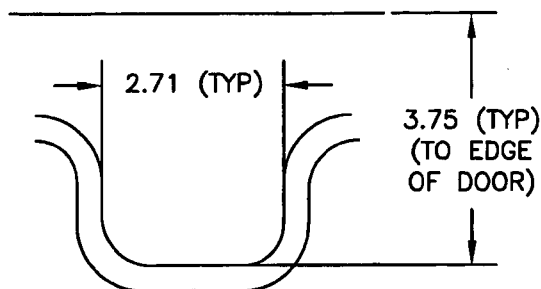
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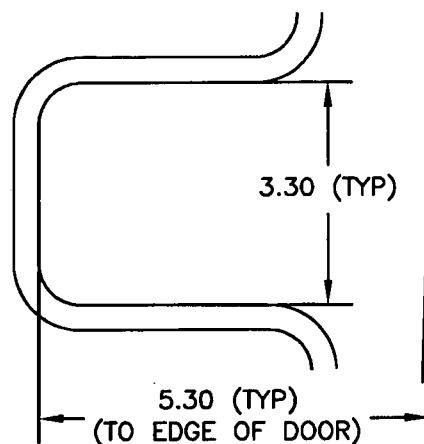
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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS



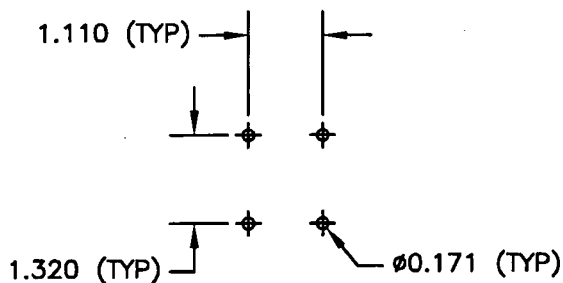
DETAIL A



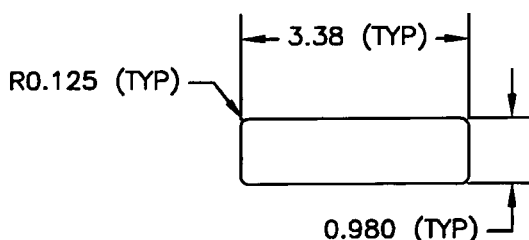
DETAIL B

RELEASED

07.02.22 [Signature]

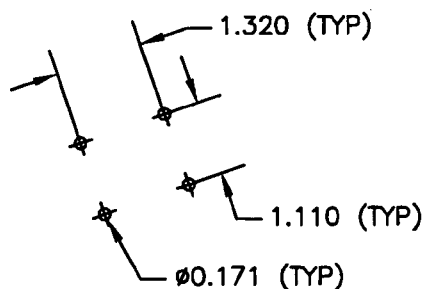


DETAIL C

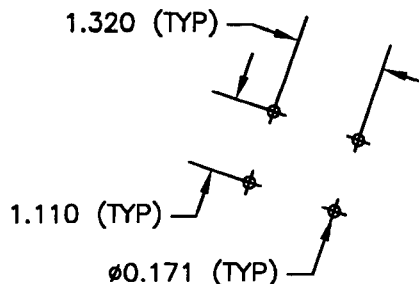


NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

DETAIL D



DETAIL E



DETAIL F

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